

(12) **United States Patent**
Veto et al.

(10) **Patent No.:** **US 10,247,318 B2**
(45) **Date of Patent:** ***Apr. 2, 2019**

(54) **STACKED DISK CHECK VALVE**
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(*) Notice: Subject to any disclaimer, the term of this patent is extended or adjusted under 35 U.S.C. 154(b) by 166 days.
This patent is subject to a terminal disclaimer.

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(21) Appl. No.: **15/228,735**
(22) Filed: **Aug. 4, 2016**

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Primary Examiner — Robert K Arundale
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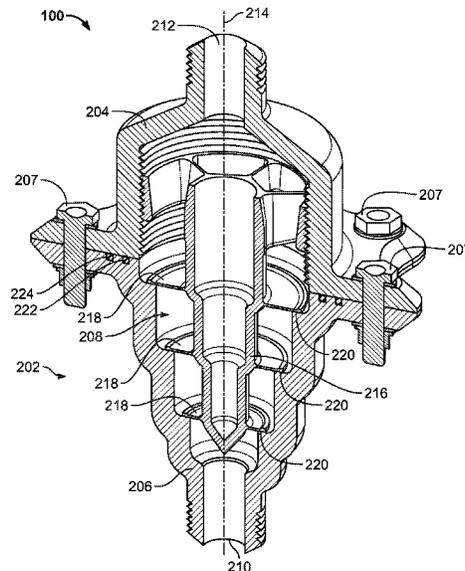
(65) **Prior Publication Data**
US 2018/0038497 A1 Feb. 8, 2018

(51) **Int. Cl.**
F16K 31/36 (2006.01)
F16K 15/14 (2006.01)
F16K 1/44 (2006.01)
(52) **U.S. Cl.**
CPC **F16K 15/148** (2013.01); **F16K 1/443** (2013.01); **Y10T 137/7832** (2015.04); **Y10T 137/7842** (2015.04); **Y10T 137/7879** (2015.04)

(57) **ABSTRACT**
Fluid apparatus and related methods are disclosed. An example fluid apparatus includes a housing defining a fluid flow passageway between an inlet and an outlet. The housing has a first valve seat and a second valve seat positioned in the fluid flow passageway. The first valve seat is spaced from the second valve seat. A flow control member is positioned in the fluid flow passageway. The flow control member has a first disk and a second disk. The first disk is to engage the first valve seat and the second disk to engage the second valve seat.

(58) **Field of Classification Search**
CPC Y10T 137/7838; Y10T 137/7842; Y10T 137/7845; Y10T 137/7846; Y10T 137/789
See application file for complete search history.

19 Claims, 21 Drawing Sheets



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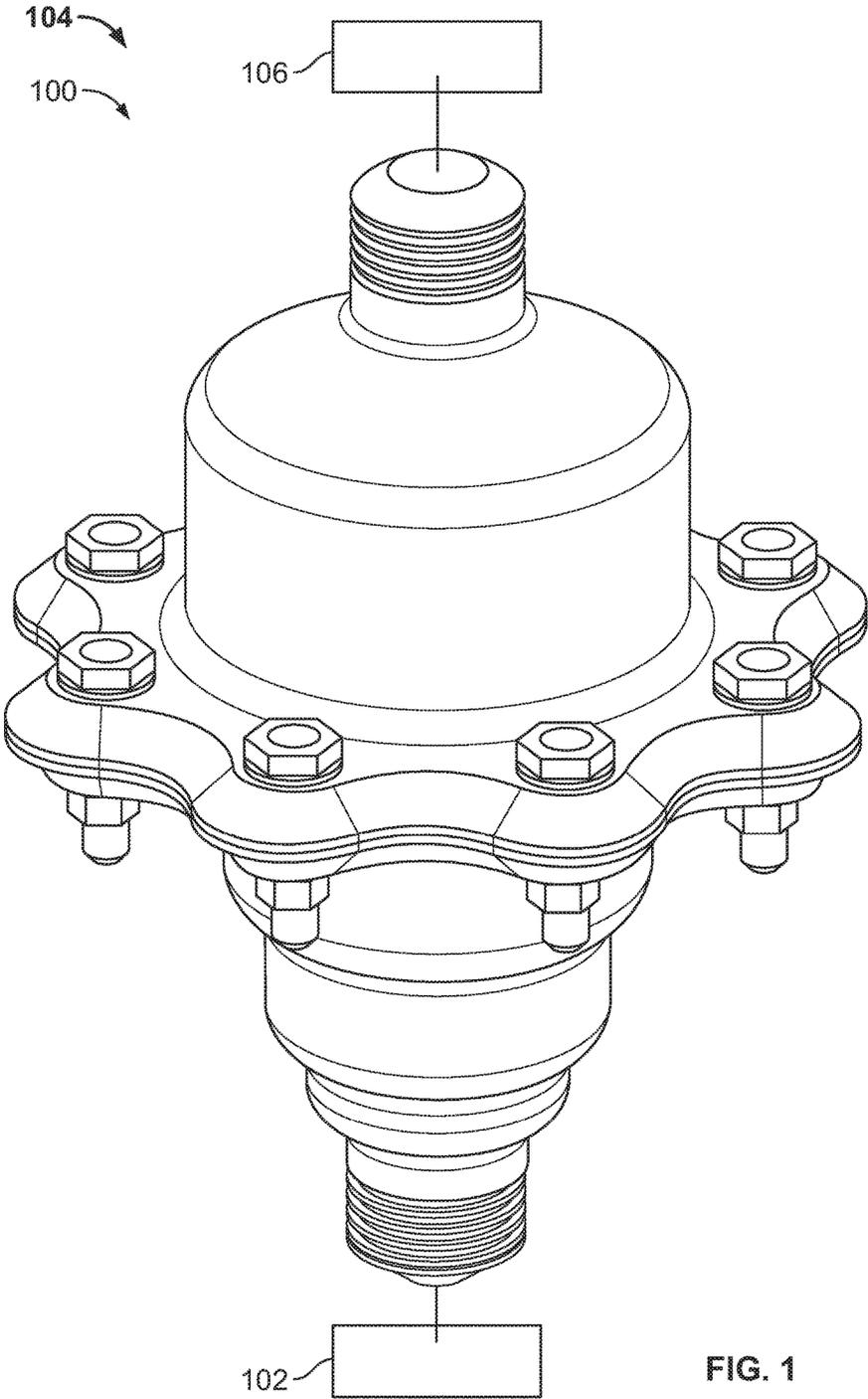
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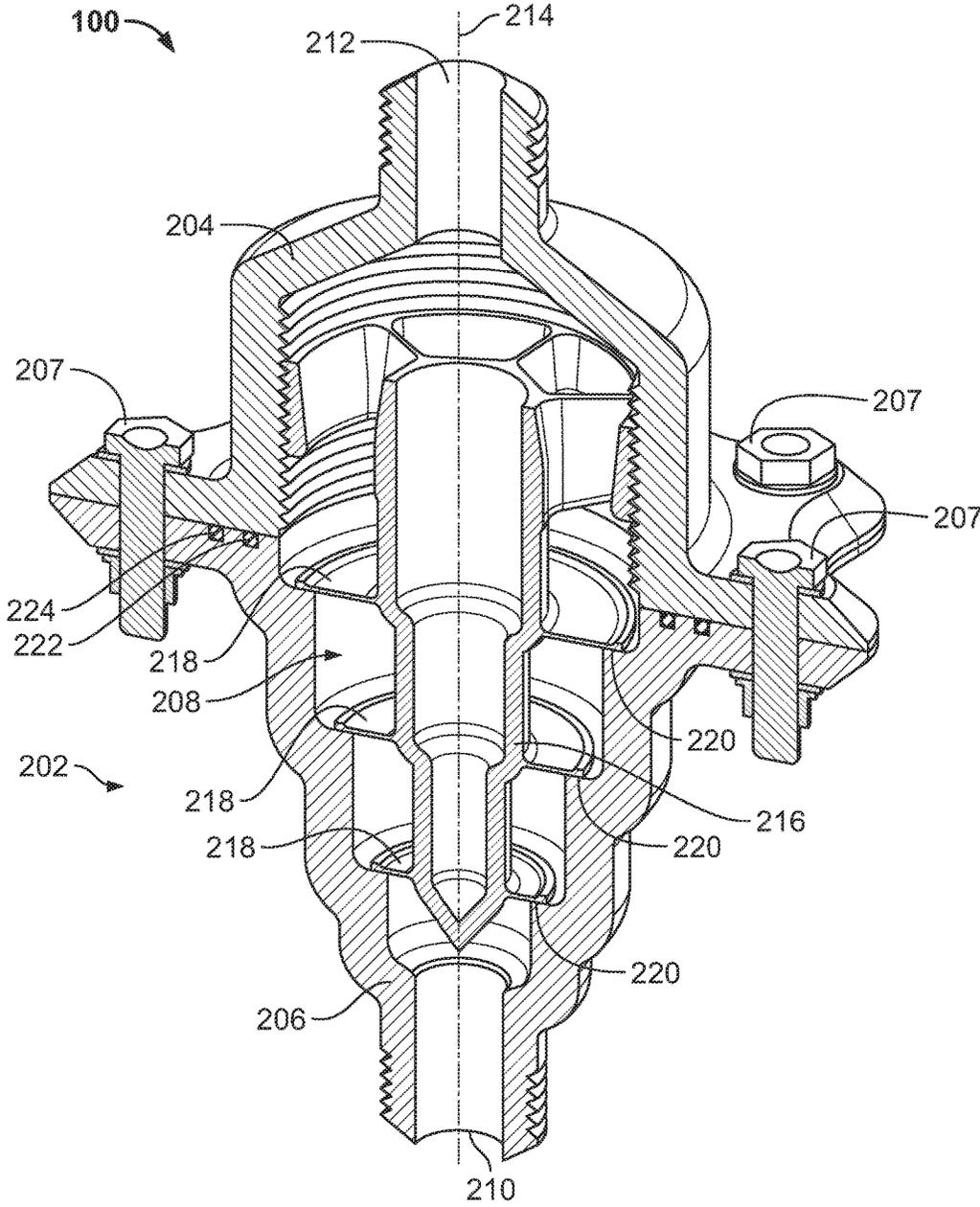


FIG. 2

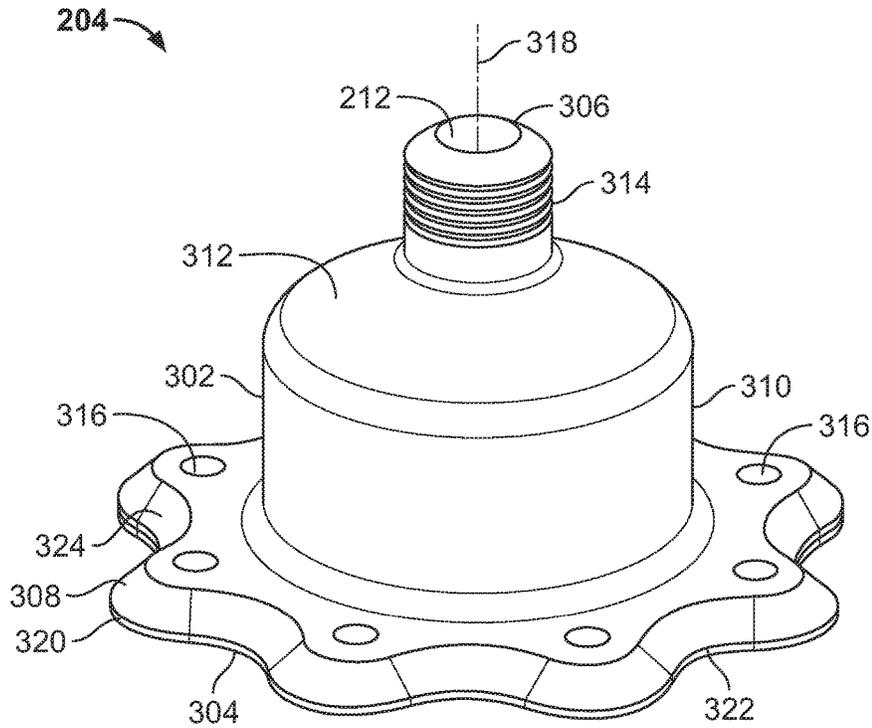


FIG. 3

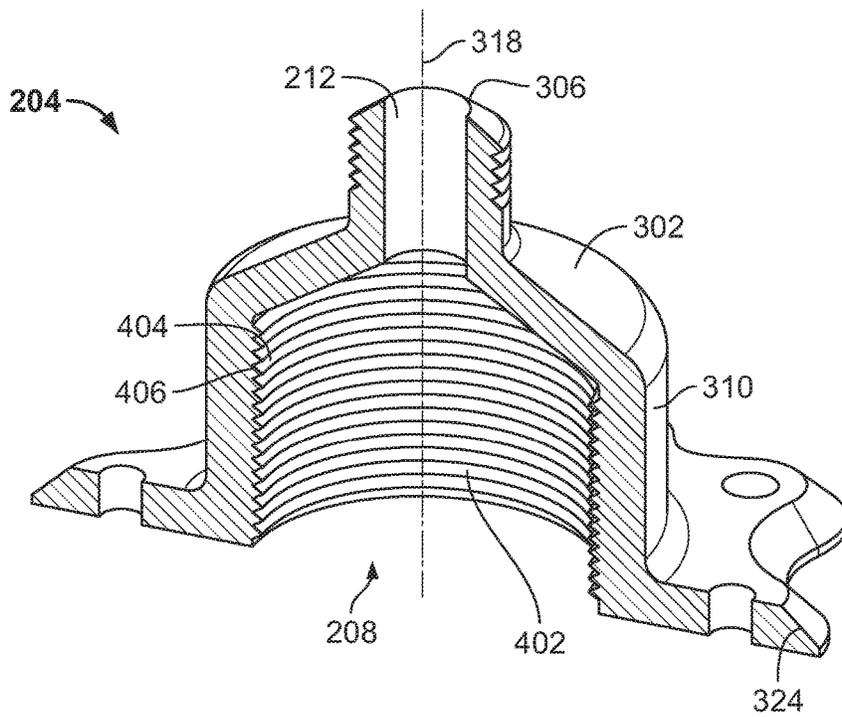


FIG. 4

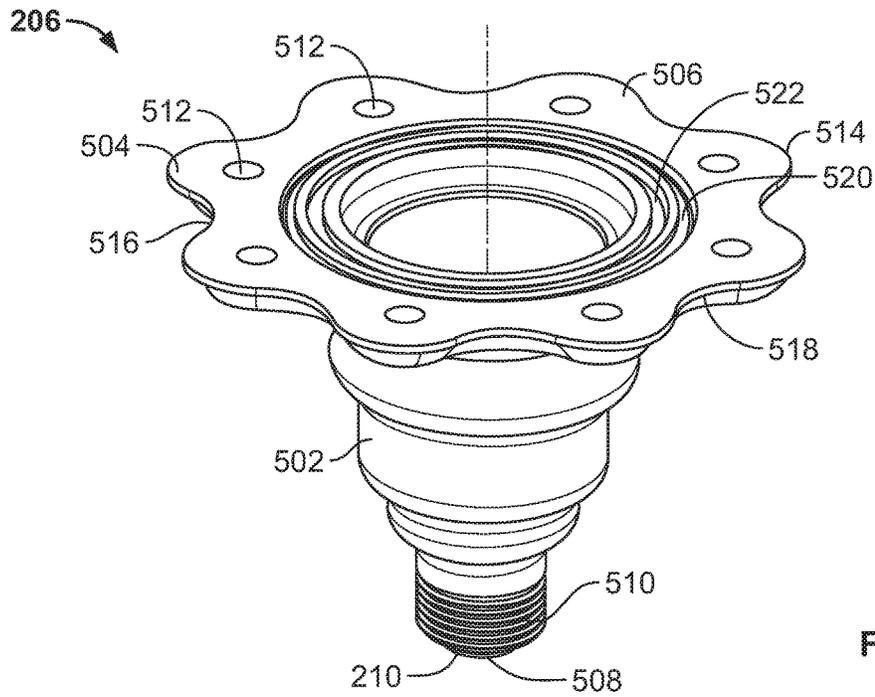


FIG. 5

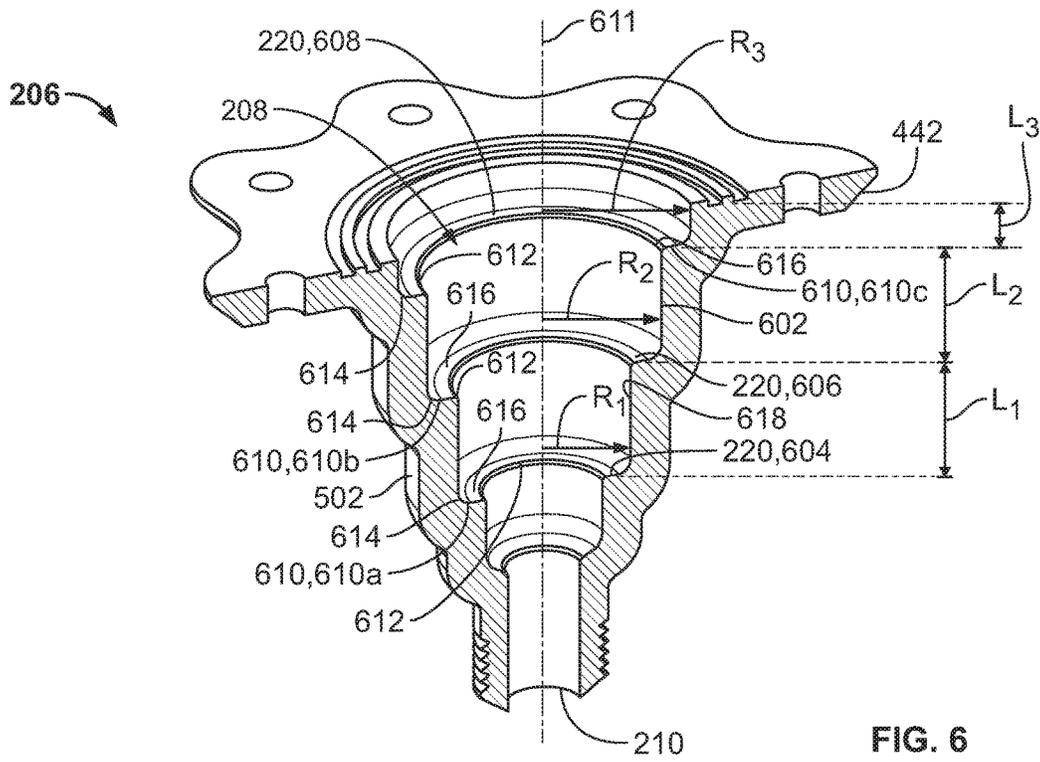


FIG. 6

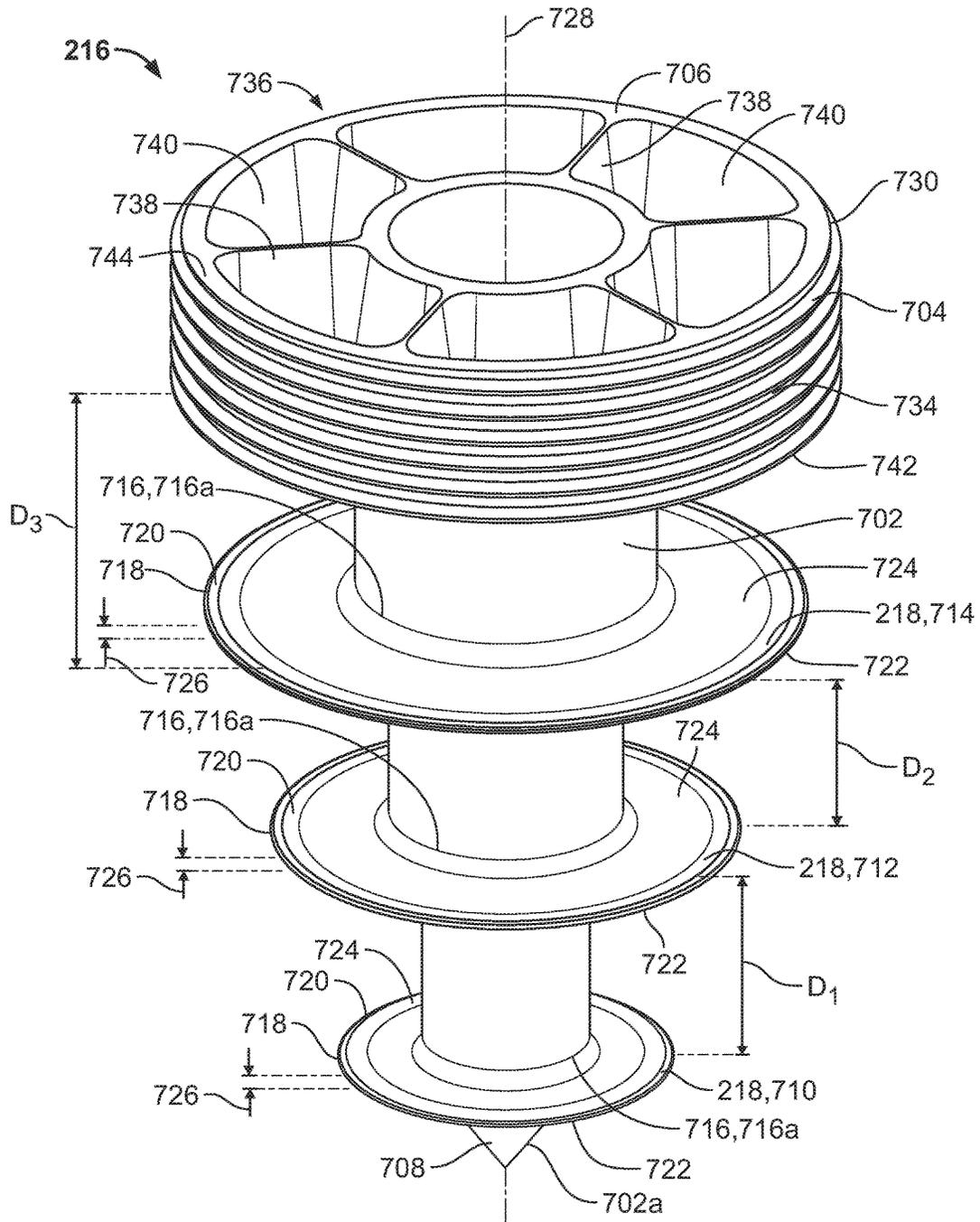


FIG. 7A

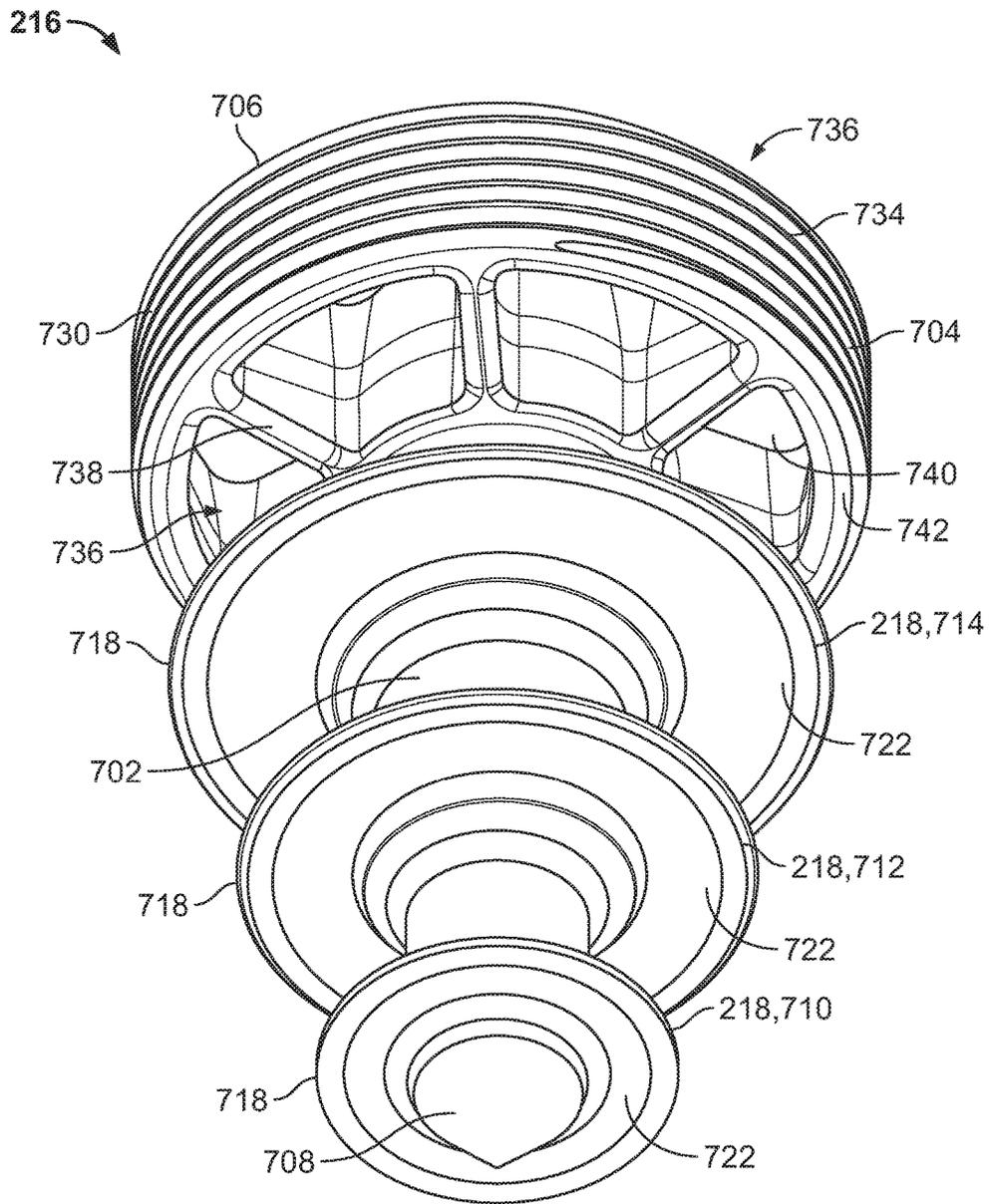


FIG. 7B

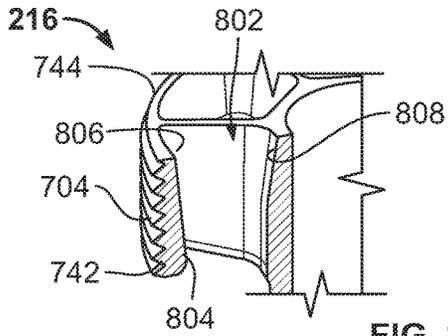


FIG. 8A

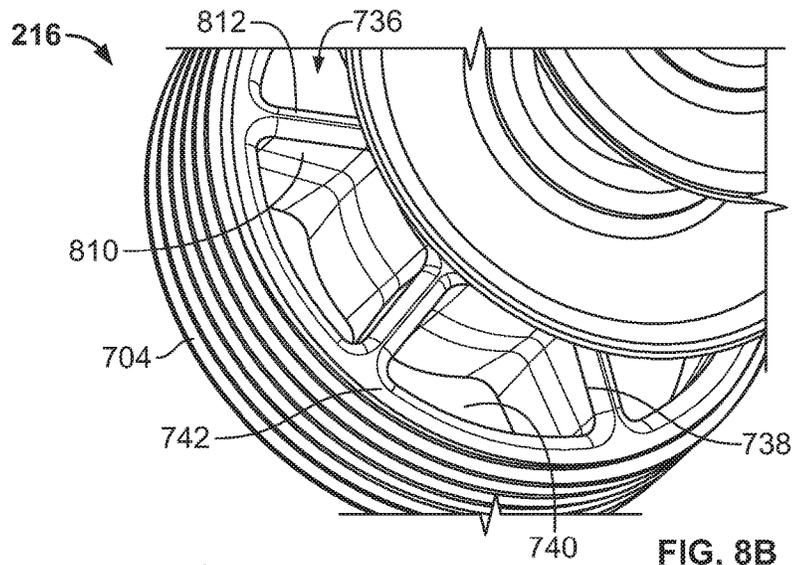


FIG. 8B

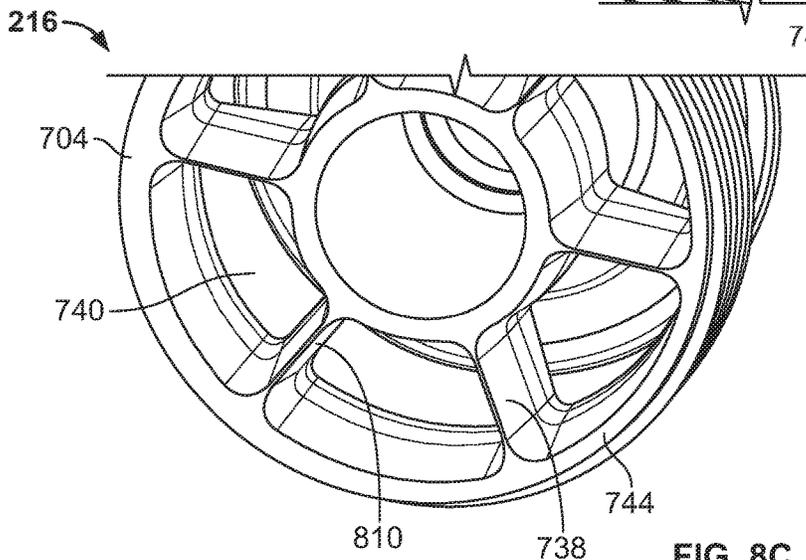
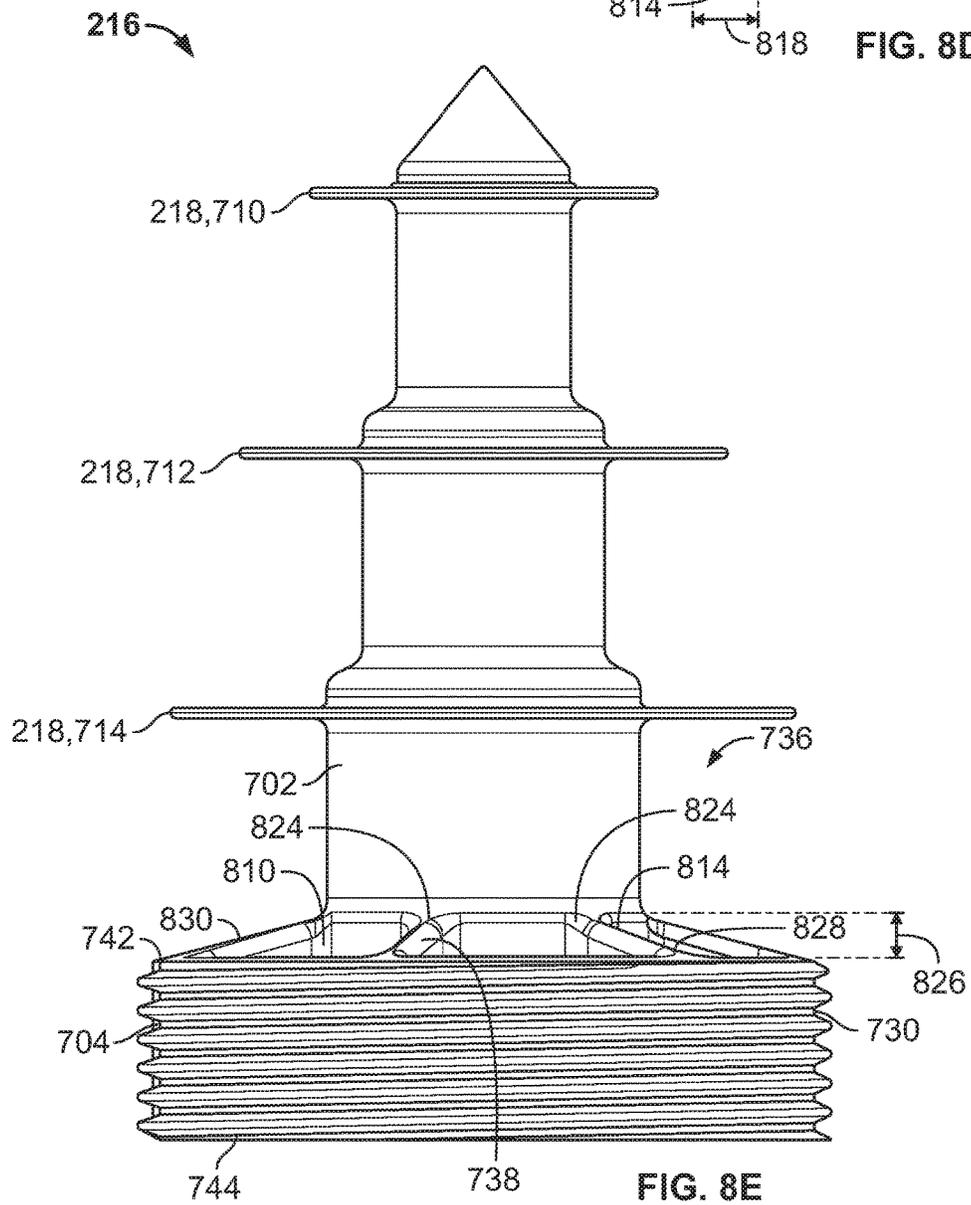
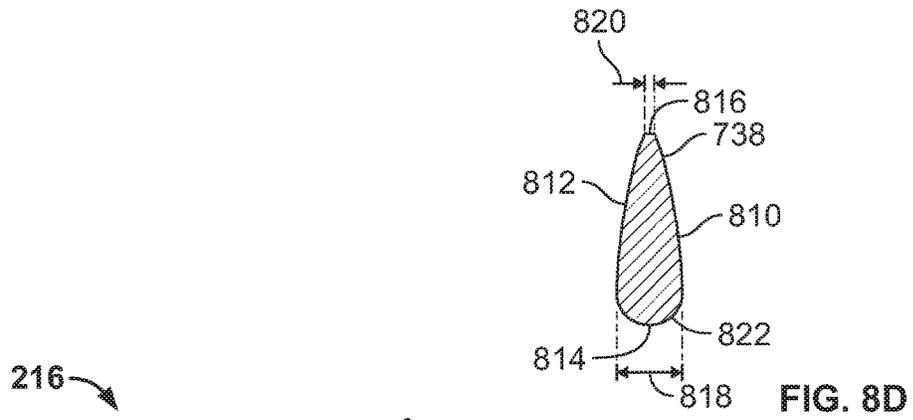


FIG. 8C



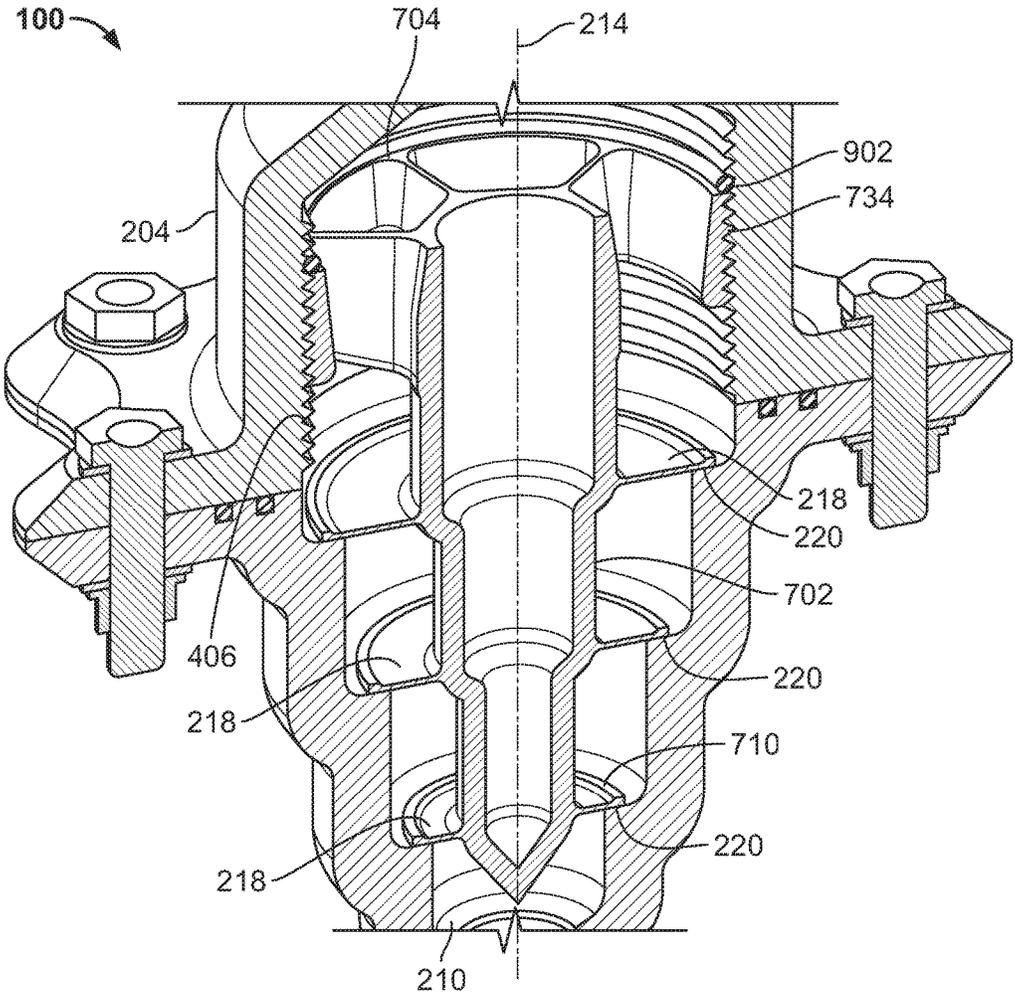


FIG. 9

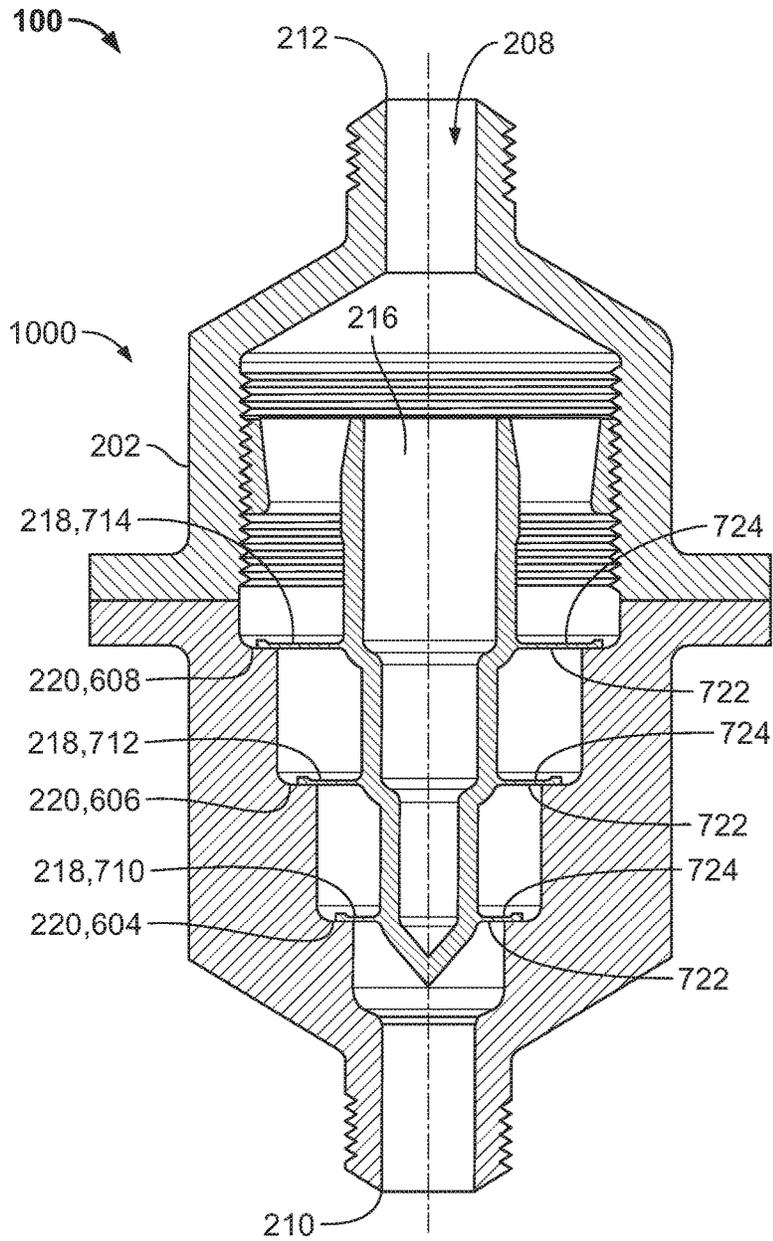


FIG. 10

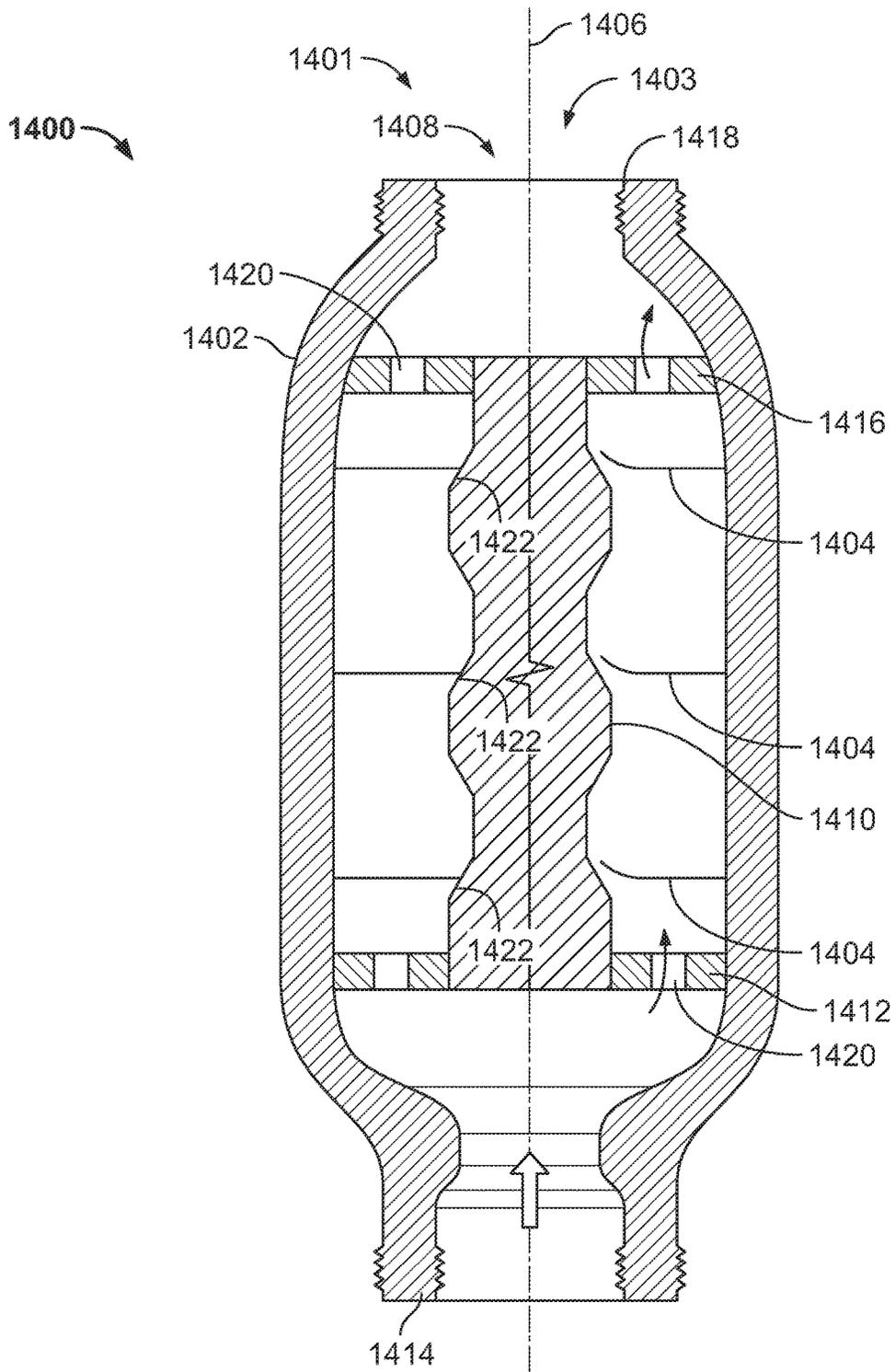


FIG. 14

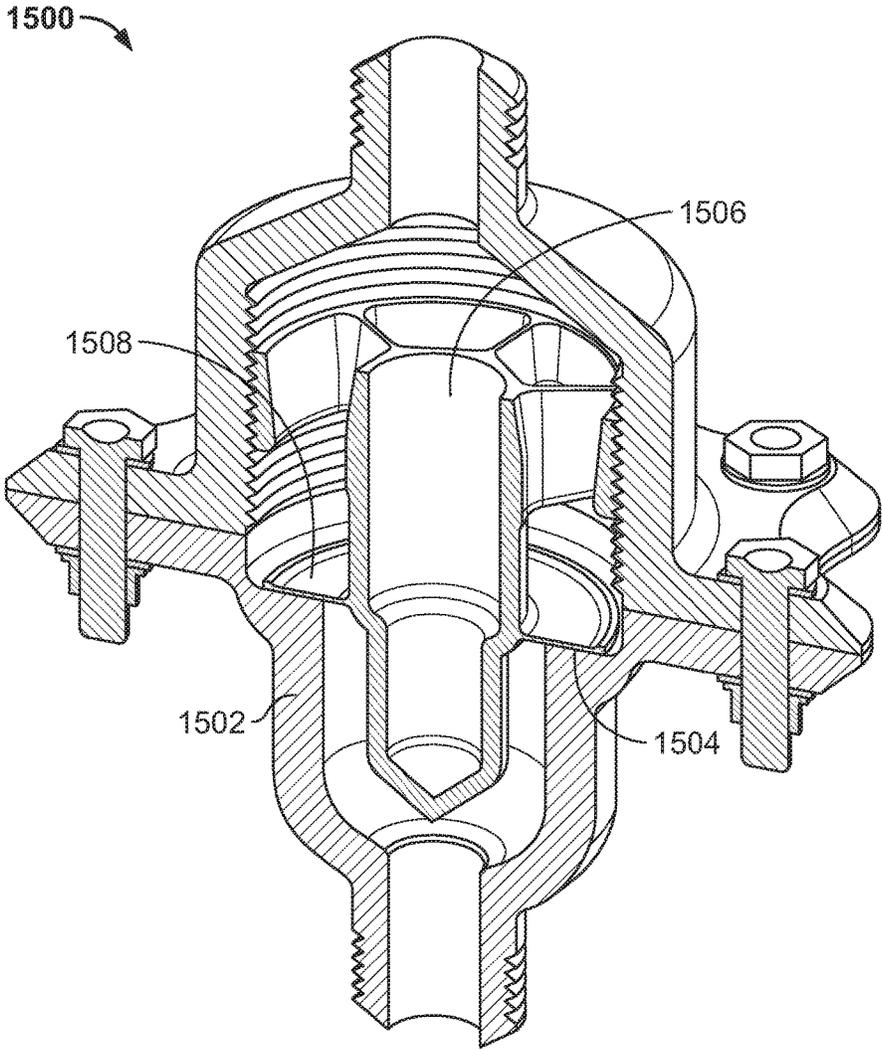


FIG. 15

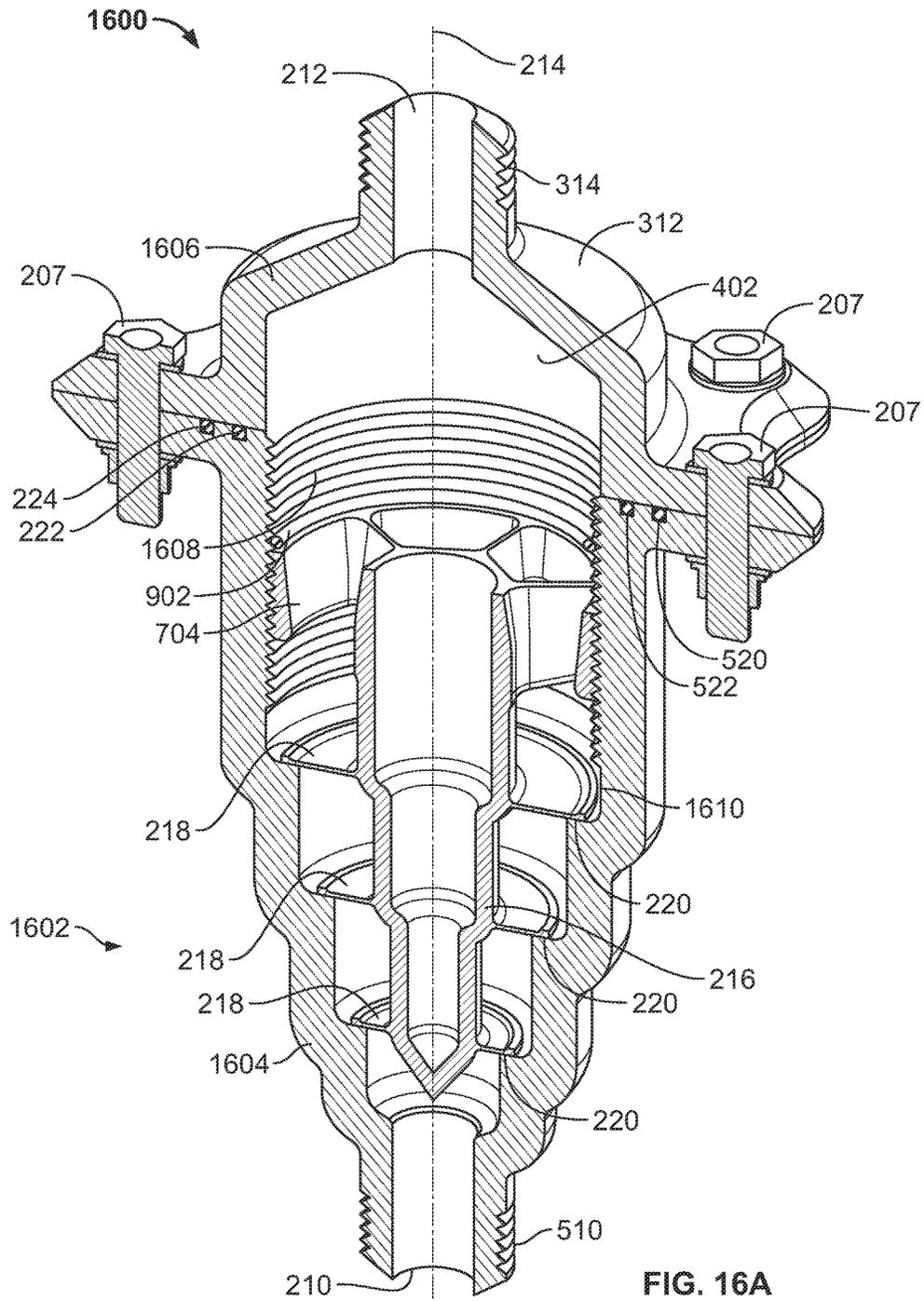


FIG. 16A

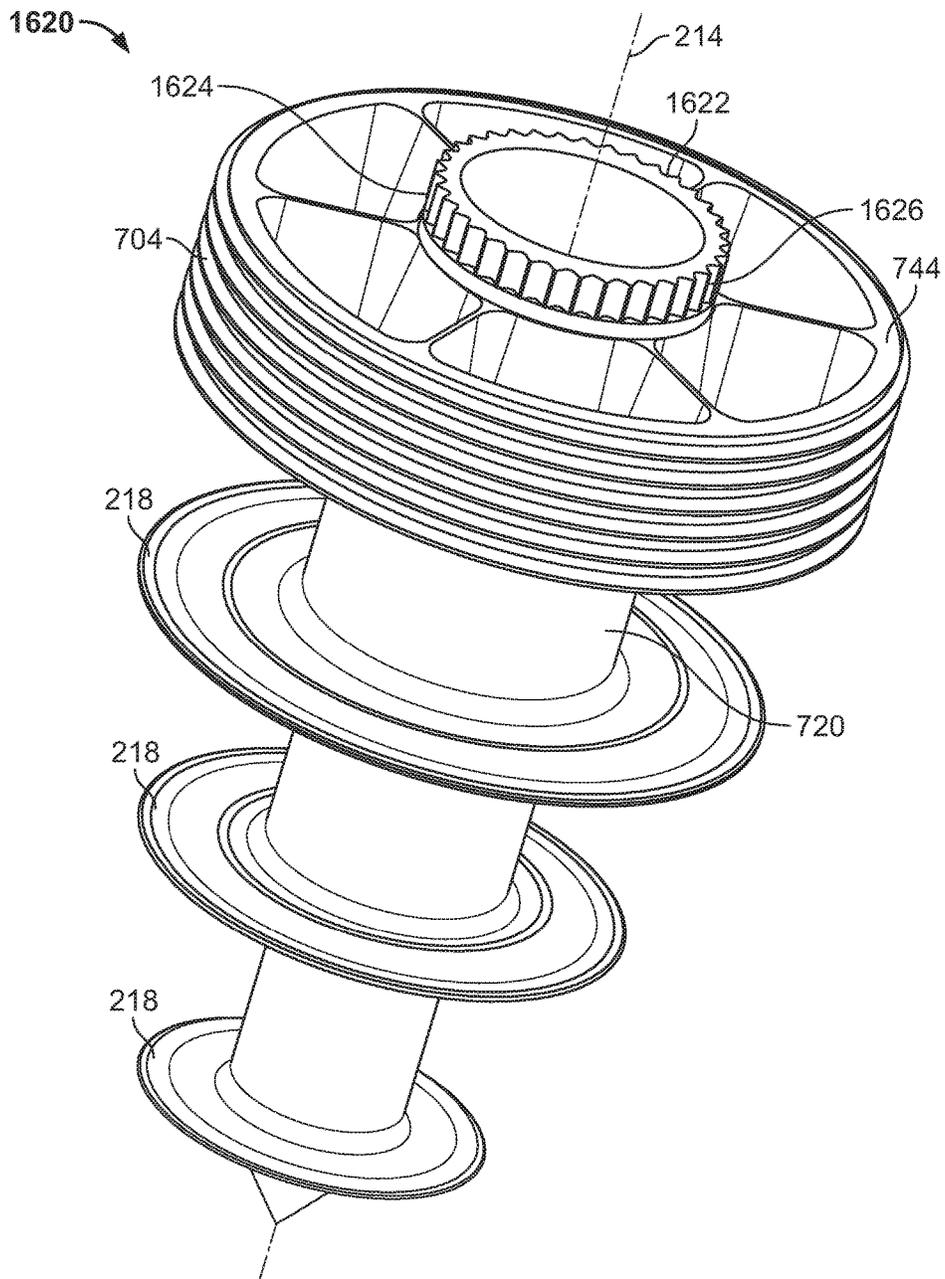


FIG. 16B

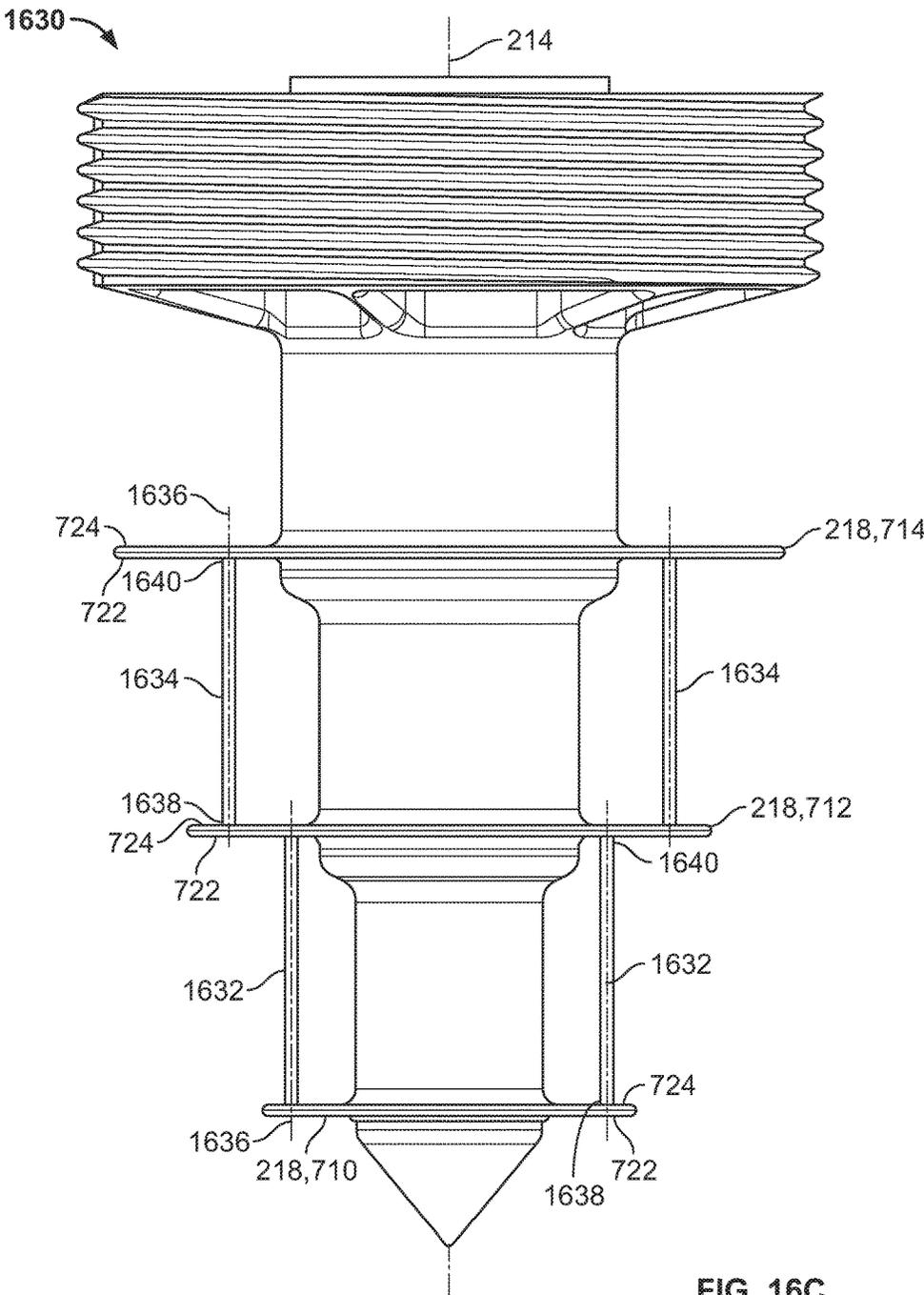


FIG. 16C

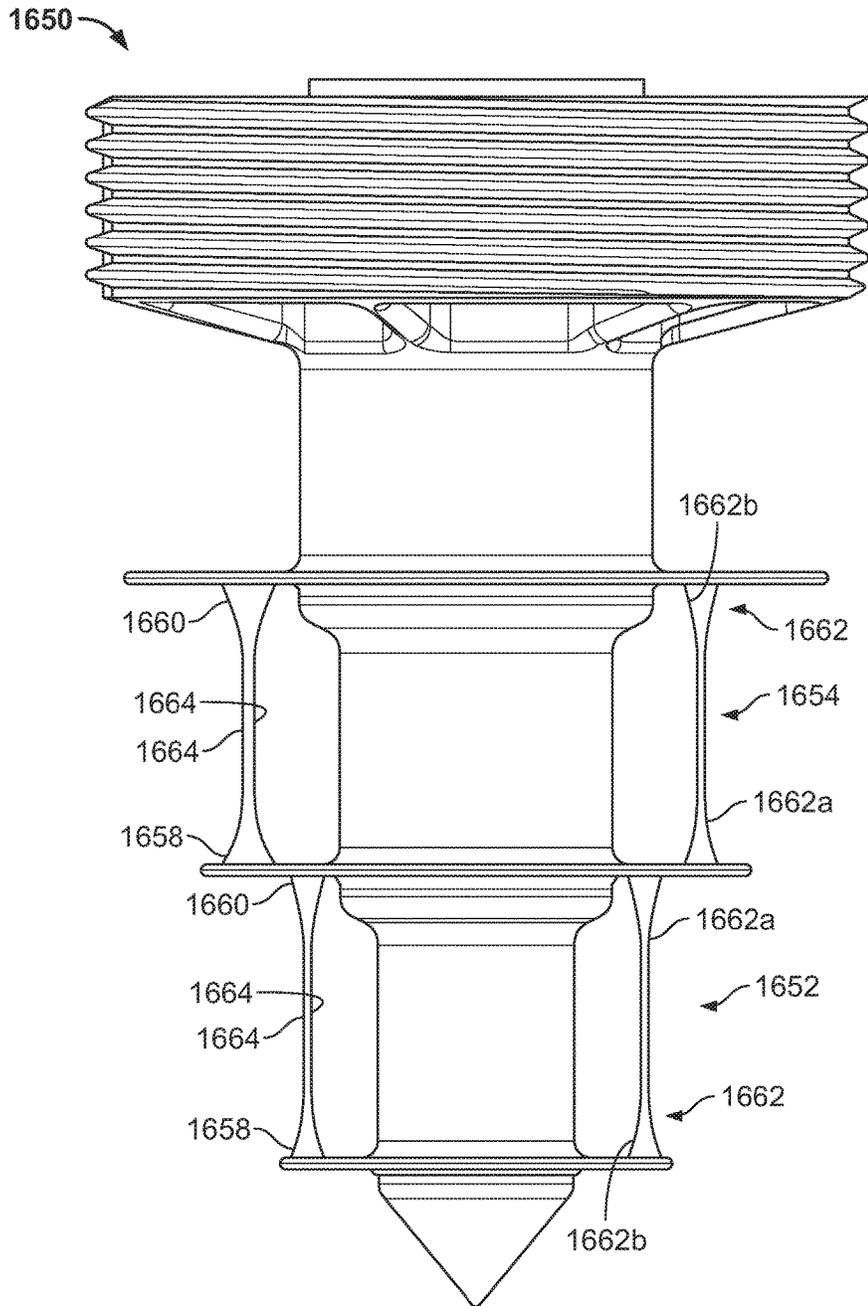


FIG. 16D

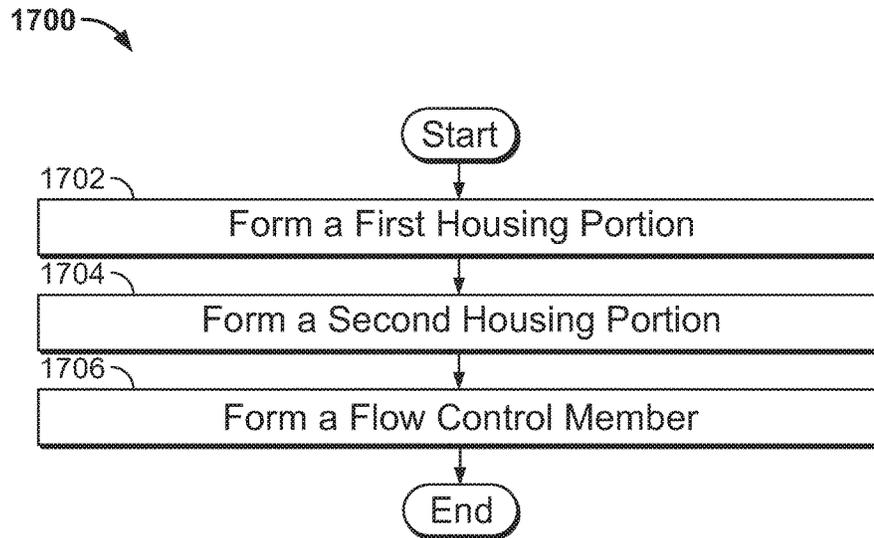


FIG. 17

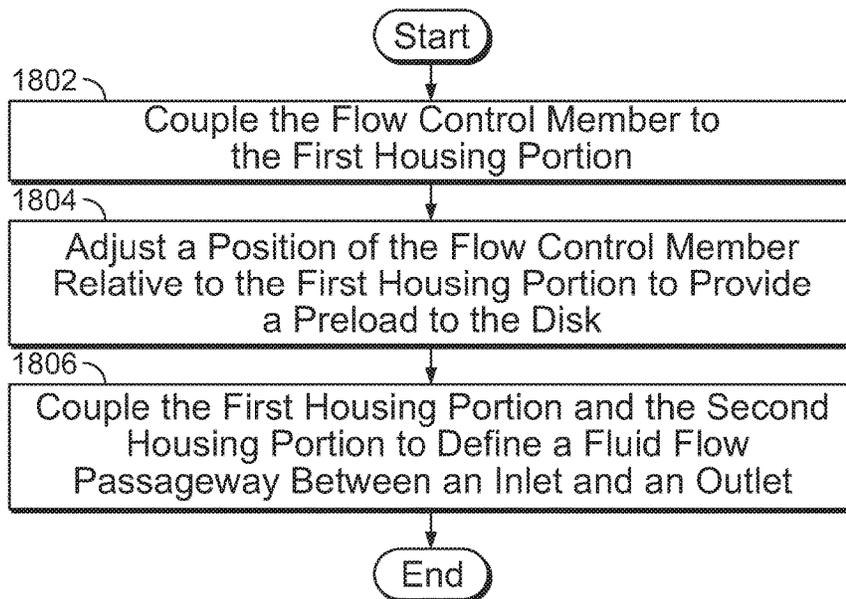


FIG. 18

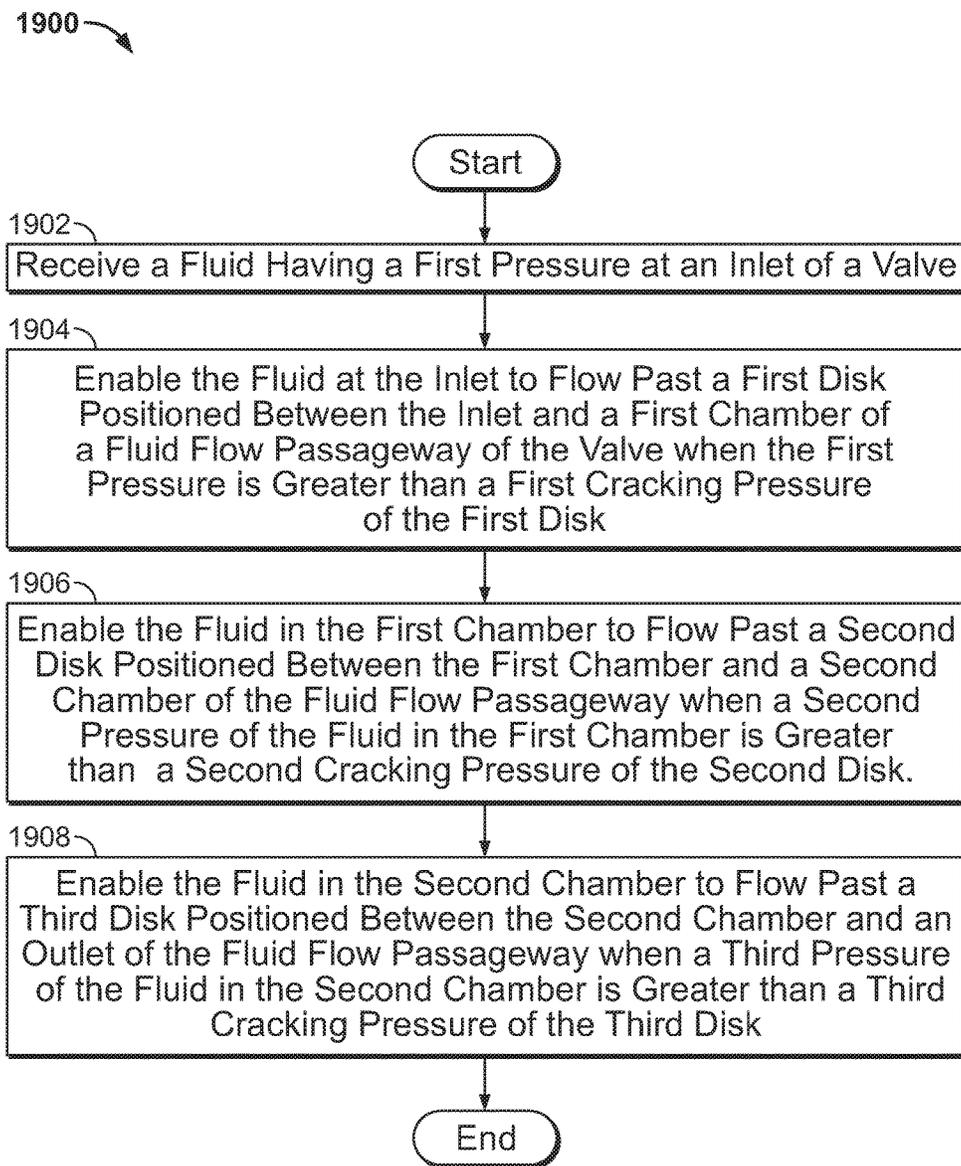


FIG. 19

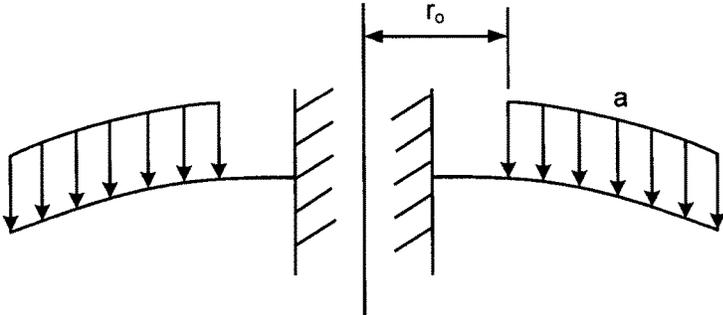


FIG. 20

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STACKED DISK CHECK VALVE

GOVERNMENT CONTRACT

This invention was made with government support under HR0011-14-9-0005. The government has certain rights in the invention.

FIELD OF THE DISCLOSURE

This patent relates generally to fluid devices and, more particularly, to valve apparatus and related methods.

BACKGROUND

Fluid systems (e.g., fuel systems, propulsion systems, hydraulic systems, etc.) often employ fluid devices (e.g., check valves) to prevent reverse fluid flow through the system. For example, a space shuttle propulsion system may employ check valves to prevent reverse fluid flow to a main engine of a space shuttle. Check valves typically include a ball valve that moves relative to a valve seat to control fluid flow through the check valve. In some examples, a spring is often employed to bias the ball valve into sealing engagement with the valve seat. In some examples, the spring may be adjustable to vary a preload to adjust or set a desired cracking pressure of the valve (i.e., a pressure at which the ball valve moves to an open position away from the valve seat to allow fluid through the valve). However, in some instances, the spring may wear or fracture due to cyclic fatigue or cryogenic shock. As a result, the valve may open at a pressure less than the desired cracking pressure provided by the initial preload or, alternatively, there may be reverse flow (fluid flow from the outlet toward the inlet). In some instances, a change in pressure across an orifice of the fluid valve may produce vibration having a frequency similar or the same as a resonant frequency of the spring, which causes chattering. In some instances, for example during high vibrational applications, the ball valve may dislodge (e.g., from the impetus of the spring) and fall from the valve seat.

Some known check valves employ a spring-biased swing flapper. However, in some applications, fluid flow may cause cyclic wear on the spring and/or flapper due to spring-flapper oscillations. In some examples, springless or spring-free check valves employ a flap that moves or deflects relative to a valve seat to control fluid flow. However, a cracking pressure of springless check valves may not be adjustable. In some instances, the flaps could chatter and/or become damaged during high vibrational applications. Thus, the flap may be subject to chatter during certain flow conditions that prevent the flap from providing a desired shut-off or seal.

SUMMARY

An example fluid apparatus includes a housing defining a fluid flow passageway between an inlet and an outlet. The housing has a first valve seat and a second valve seat positioned in the fluid flow passageway. The first valve seat is spaced from the second valve seat. A flow control member is positioned in the fluid flow passageway. The flow control member has a first disk and a second disk. The first disk is to engage the first valve seat and the second disk to engage the second valve seat.

Another example apparatus includes a housing defining a valve seat positioned in a fluid flow passageway between an inlet and an outlet and a flow control member positionable

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in the fluid flow passageway. The flow control member includes: a body; a disk coupled to the body, where the disk has a center portion coupled to the body and a peripheral edge extending from the center portion; and a head portion to couple the flow control member to the housing.

Another example apparatus includes a bonnet having a cavity and defining an outlet. A valve body to be coupled to the bonnet, where the valve body defines an opening including a first valve seat, a second valve seat and an inlet. A poppet has a body and a head, where the head is to be positioned in the cavity of the bonnet and at least a portion of the body is to be positioned in the opening of the valve body. The poppet has a first disk and a second disk spaced from the first disk. The first disk has a first aperture to receive the body of the poppet and a first peripheral edge to engage the first valve seat. The second disk has a second aperture to receive the body of the poppet and a second peripheral edge to engage the second valve seat. The head of the poppet is coupled to the bonnet via threads to enable adjustment of a preload of at least the first disk or the second disk.

An example method includes forming a first housing; forming a second housing having a plurality of valve seats, where the first housing is to be coupled to the second housing to define a valve body defining a fluid flow passageway between an inlet and an outlet of the fluid valve; forming a flow control member having a plurality of disks spaced along a longitudinal axis of the flow control member; and positioning the flow control member in the fluid flow passageway such that a respective one of the disks engages a respective one of the valve seats.

Another example method includes receiving a fluid at an inlet of a valve body, where the valve body defining a fluid flow passageway between the inlet and an outlet, and where the fluid at the inlet has a first pressure; enabling the fluid at the inlet to flow past a first disk positioned between the inlet and a first chamber of the fluid flow passageway when the first pressure is greater than a first cracking pressure of the first disk; and enabling the fluid in the first chamber to flow past a second disk positioned between the first chamber and a second chamber of the fluid flow passageway downstream from the first chamber when a second pressure of the fluid in the second chamber is greater than a second cracking pressure of the second disk.

BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is a perspective view of an example fluid apparatus constructed in accordance with the teachings disclosed herein.

FIG. 2 is a cross-sectional view of the fluid apparatus of FIG. 1.

FIG. 3 is a perspective view of an example first housing of the example fluid apparatus of FIGS. 1-2.

FIG. 4 is a perspective, cross-sectional view of the example first housing of FIG. 3.

FIG. 5 is a perspective view of an example second housing of the example fluid apparatus of FIGS. 1-2.

FIG. 6 is a perspective, cross-sectional view of the example second housing of FIG. 5.

FIG. 7A is a perspective view of an example flow control member of the example fluid apparatus of FIGS. 1 and 2.

FIG. 7B is another perspective view of an example flow control member of the example fluid apparatus of FIGS. 1, 2, and 7B.

FIG. 8A is an enlarged, cross-sectional view of a portion of the example flow control member of FIGS. 1, 2, 7A and 7B.

FIGS. 8B and 8C are partial, perspective views of the example flow control member of FIGS. 1, 2, 7A and 7B.

FIG. 8D is a cross-sectional view of a rib of the example flow control member of FIGS. 1, 2, 7A, 7B and 8A-8C.

FIG. 8E is a side view of the example flow control member of FIGS. 1, 2, 7A, 7B, and 8A-8D.

FIG. 9 is another perspective, cross-sectional view of an example fluid apparatus of FIGS. 1-6, 7A-7B, and 8A-8E.

FIG. 10 is a cross-sectional view of the example fluid apparatus of FIGS. 1-6, 7A-7B, 8A-8E and 9 shown in a closed position.

FIG. 11 is a cross-sectional view of the example fluid apparatus of FIGS. 1-6, 7A-7B, 8A-8E, 9 and 10 shown in an open position.

FIG. 12 is a cross-sectional view of another example fluid apparatus disclosed herein.

FIG. 13 is a cross-sectional view of another example fluid apparatus disclosed herein.

FIG. 14 is a cross-sectional view of another example fluid control apparatus disclosed herein.

FIG. 15 is a perspective, cross-sectional view of another example fluid apparatus disclosed herein.

FIG. 16A is a perspective, cross-sectional view of another example fluid apparatus disclosed herein.

FIG. 16B is a perspective view of another example flow control member disclosed herein that may implement an example fluid apparatus disclosed herein.

FIG. 16C illustrates another example flow control member disclosed herein that may implement an example fluid apparatus disclosed herein.

FIG. 16D illustrates another example flow control member disclosed herein that may implement an example fluid apparatus disclosed herein.

FIG. 17 illustrates an example method to manufacture, fabricate or assemble an example fluid apparatus disclosed herein.

FIG. 18 illustrates an example method to assemble an example fluid apparatus disclosed herein.

FIG. 19 illustrates an example method of operation an example fluid apparatus disclosed herein.

FIG. 20 is an illustration of a beam loading/bending schematic.

Wherever possible, the same reference numbers will be used throughout the drawing(s) and accompanying written description to refer to the same or like parts. As used in this description, stating that any part (e.g., a layer, film, area, or plate) is in any way positioned on (e.g., positioned on, located on, disposed on, or formed on, etc.) another part, means that the referenced part is either in contact with the other part, or that the referenced part is above the other part with one or more intermediate part(s) located there between. Stating that any part is in direct contact with another part means that there is no intermediate part between the two parts. As used herein, substantially and approximately mean within about 10% different than the number at issue. For example, substantially perpendicular means 90 degrees plus or minus 10%. For example, approximately 90 degrees means 90 degrees plus or minus 10% (e.g., between about 81 degrees and 99 degrees). In some examples, substantially parallel means 0 degrees plus or minus 10 degrees.

DETAILED DESCRIPTION

The example fluid apparatus disclosed herein may be employed with control systems to control the flow of fluids.

In some examples, the example fluid apparatus disclosed herein may be configured as check valves that prevent reverse fluid flow through a fluid control system (e.g., a fuel system, a hydraulic system, etc.). The example fluid apparatus disclosed herein may be employed with aerospace applications or systems (e.g., a spacecraft, an aircraft, a space station system), automotive applications or systems, industrial systems, applications having cryogenic conditions, and/or any other application or system requiring fluid flow control (e.g., prevention of reverse fluid flow). For example, the example fluid apparatus disclosed herein may be employed in propulsion systems (e.g., a rocket or spacecraft propulsion system), fuel systems (e.g., an automotive fuel system), hydraulic systems, and/or any other process or system requiring fluid flow control (e.g., prevention of reverse fluid flow).

The example fluid apparatus disclosed herein reduce weight and/or manufacturing costs compared to conventional check valves (e.g., a ball check valve, a swing valve, a diaphragm check valve, etc.). Additionally, the example fluid apparatus disclosed herein may provide improved sealing compared to conventional fluid valves (e.g., check valves). In some examples, the fluid apparatus disclosed herein may provide redundant sealing. For example, the example fluid apparatus disclosed herein may employ multiple flow control members (e.g., multiple stacked disks) and/or valve seats to provide redundant sealing. In some examples, the fluid apparatus disclosed herein may include only one disk and/or only one valve seat.

In some examples, the fluid apparatus disclosed herein enable preload or cracking pressure tuning or adjustment without use of a spring. For example, a cracking pressure or pressure required to open the example fluid apparatus may be adjusted or varied to a desired pressure without requiring use of a biasing element or spring. For example, to adjust a cracking pressure or preload of the valve, an example flow control member disclosed herein includes a threaded portion to engage a threaded wall of a housing to enable (e.g., linear) adjustment of the flow control member along the longitudinal axis. In some examples, a passageway and/or a rib of the example fluid flow control members disclosed herein may include a profile (e.g., an airfoil profile and/or a tapered profile) to promote laminar flow characteristics and/or prevent turbulent fluid flow characteristics when fluid flows through the fluid apparatus. In some examples, the fluid apparatus disclosed herein may be conducive to cryogenic environments or conditions and/or are resistant to vibration loading. In some examples, the fluid apparatus disclosed herein may be composed of any material(s) or alloys such as, for example, Inconel, steel, aluminum, plastic, PTFE, Teflon, and/or any other material(s). In some examples, the material of the flow control member may provide different cracking pressures based on a temperature of a process fluid and/or a temperature of an environment of the valve. In some examples, the example fluid apparatus disclosed herein may be manufactured using an additive manufacturing process (e.g., a direct metal laser sintering additive manufacturing process), injection molding, machining and/or any other manufacturing process(es). In some examples, the fluid apparatus disclosed herein employ a plurality of disks. In some examples, the disks are spaced along a longitudinal axis of a flow control member. In some examples, the disks are concentric.

FIG. 1 illustrates an example fluid apparatus 100 in accordance with the teachings of this disclosure. The example fluid apparatus 100 of the illustrated example is a check valve that enables one-way fluid flow from an

upstream source **102** of a system **104** toward a downstream source **106** of the system **104**. In addition, the example fluid apparatus **100** of the illustrated example prevents fluid flow from the downstream source **106** toward the upstream source **102**. In some examples, the system **104** may be a portion of a space shuttle main propulsion system and/or another re-entry vehicle. For example, the upstream source **102**, the fluid apparatus **100** and the downstream source **106** may be part of a bleed return line of a spacecraft propulsion system.

FIG. 2 is a cross-sectional, perspective view of the example fluid apparatus **100** of FIG. 1. The example fluid apparatus of the illustrated example includes a housing **202** having a first housing portion **204** (e.g., a bonnet) coupled to a second housing portion **206** (e.g., a valve body). The first housing portion **204** and the second housing portion **206** of the illustrated example (e.g., when coupled together via, for example, fasteners **207**) define a fluid flow passageway **208** (e.g., an axial fluid flow path) between an inlet **210** and an outlet **212**. The inlet **210** of the illustrated example is coaxially aligned with the outlet **212**. Additionally, the inlet **210** and the outlet **212** of the illustrated example are coaxially aligned relative to a longitudinal axis **214** of the fluid apparatus **100** and/or the fluid flow passageway **208**. In some examples, the inlet **210** may not be coaxially aligned with the outlet **212** and/or the longitudinal axis **214**.

To control fluid flow between the inlet **210** and the outlet **212** the example fluid apparatus **100** includes a flow control member **216** (e.g., a poppet) positioned in the fluid flow passageway **208**. In the illustrated example, the flow control member **216** includes radial flanges or disks **218** (e.g., multiple stacked disks). In particular, the disks **218** of the example flow control member **216** are spaced along a length of the flow control member **216** (e.g., concentrically aligned). The disks **218** of the example flow control member **216** move relative to (e.g., engage and disengage) respective valve seats **220** of the fluid apparatus **100** to control (e.g., prevent or allow) fluid flow through the fluid flow passageway **208**. As described in greater detail below, the example disks **218** provide redundant sealing. In addition, the example flow control member **216** of the illustrated example provides a preload to the disks **218** without use of a biasing element such as, for example, a spring. Seals **222** and **224** between the first housing portion **204** and the second housing portion **206** prevent fluid flow leakage external of the housing **202** when fluid flows between the inlet **210** and the outlet **212**.

FIG. 3 is a perspective view of the first housing portion **204** of FIGS. 1 and 2. The first housing portion **204** of the illustrated example includes a body **302** having a first end **304** and a second end **306** opposite the first end **304**. The body **302** of the illustrated example includes a flange **308** adjacent the first end **304** and the outlet **212** adjacent the second end **306**. The body **302** of the illustrated example includes a cylindrical portion **310** extending from the flange **308** and a tapered portion **312** extending between the cylindrical portion **310** and the outlet **212**. To couple the downstream source **106** (FIG. 1) to the fluid apparatus **100**, the body **302** of the illustrated example includes a fitting **314**. In the illustrated example, the fitting **314** is integrally formed with the body **302** and extends from the tapered portion **312**. The fitting **314** of the illustrated example is a threaded male fitting. In some examples, the fitting **314** may be a threaded female fitting, a barb, a quick disconnect fitting, a swage lock, a flange, and/or any other fitting(s). The flange **308** of the illustrated example includes holes **316** radially spaced relative to a longitudinal axis **318** of the body

302. To reduce mass, material cost, manufacturing time, etc., a peripheral edge **320** of the flange **308** of the illustrated example includes a sinusoidal shape or profile **322** and a chamfer **324** (e.g., a 45 degree angle). In some examples, the peripheral edge **320** of the flange **308** may include a circular shape or any other shape and/or may not include the chamfer **324**.

FIG. 4 illustrates a cross-sectional, perspective view of the first housing portion **204** of FIG. 3. The body **302** of the first housing portion **204** has a cavity **402** to form a portion of the fluid flow passageway **208** of the fluid apparatus **100**. In the illustrated example, at least a portion of an inner surface **404** of the cylindrical portion **310** includes threads **406**. As described in greater detail below, the threads **406** of the body **302** couple the flow control member **216** to the fluid apparatus **100**.

FIG. 5 is a perspective view of the example second housing portion **206** of FIGS. 1 and 2. The second housing portion **206** includes a body **502** (e.g., a cylindrical body) and a flange **504**. The flange **504** is adjacent a first end **506** of the body **502** (e.g., a cylindrical body) and a second end **508** of the body **502** opposite the first end **506** defines the inlet **210**. To couple the fluid apparatus **100** to the upstream source **102** of FIG. 1, the second housing portion **206** of the illustrated example includes a fitting **510** adjacent the inlet **210**. The fitting **510** of the illustrated example is integrally formed with the body **502** and is a threaded male fitting. In some examples, the fitting **510** may be a threaded female fitting, a barb, a quick disconnect fitting, a swage lock, a flange, and/or any other fitting(s). The flange **504** of the illustrated example includes holes **512**. To reduce mass, material cost, manufacturing time, etc., a peripheral edge **514** of the flange **504** of the illustrated example includes a sinusoidal shape or profile **516** and a chamfer **518** (e.g., a 45-degree angle). In some examples, the peripheral edge **514** may include a circular shape and/or may not include the chamfer **518**. To provide a seat for the seals **222** and **224** (e.g., O-rings), the body **502** of the illustrated example includes a first groove **520** (e.g., an annular groove) and a second groove **522** (e.g., an annular groove). Each of the grooves **520** and **522** of the illustrated example includes a U-shaped channel. In some examples, the first groove **520** and/or the second groove **522** may have V-shaped channel or profile.

FIG. 6 is a cross-sectional, perspective view of the example second housing portion **206** of FIG. 5. The body **502** has an opening **602** defining at least a portion of the fluid flow passageway **208**. In addition, the body **502** of the illustrated example defines the valve seats **220**. The valve seats **220** of the illustrated example are integrally formed with the body **502**. In some examples, the valve seats **220** may be separate parts that can be coupled (e.g., via threads, press-fit, etc.) to the body **502**. In the illustrated example, the body **502** includes three valve seats **604**, **606**, **608** that define respective orifices of the fluid flow passageway **208**.

To provide the valve seats **220**, the body **502** of the illustrated example includes a plurality of stepped surfaces **610**. A first stepped surface **610a** has a first dimension (e.g., a first radius R_1) relative to a longitudinal axis **611** of the body **502**, a second stepped surface **610b** has a second dimension (e.g., a second radius R_2) relative to the longitudinal axis **611**, and a third surface **610c** has a third dimension (e.g., a third radius R_3) relative to the longitudinal axis **611**. In the illustrated example, the first dimension is smaller than the second dimension and the third dimension, and the second dimension is smaller than the third dimension. However, in some examples, the first dimension may

be equal to the second dimension and/or the third dimension. In the illustrated example, the first stepped surface **610a** or valve seat **604** is spaced from the second stepped surface **610b** or valve seat **606** (e.g., in a vertical direction in the orientation of FIG. 6) by a distance L_1 and the second stepped surface **610b** or valve seat **606** is spaced from the third stepped surface **610c** or valve seat **608** by a distance L_2 (e.g., a vertical distance in the orientation of FIG. 6). The third stepped surface **610c** is spaced from first end **506** (e.g., the flange **504**) by a third distance L_3 . In some examples, the first distance L_1 is equal to the second distance L_2 and/or the third distance L_3 . In some examples, the first distance L_1 is different from the second distance L_2 and/or the third distance L_3 . In some examples, the second distance L_2 is different than the third distance L_3 .

To reduce stress concentration on the disks **218** and/or to improve sealing capability when the disks **218** engage and/or seal against the valve seats **220**, the stepped surfaces **610** may include a curved or arcuate profile **612** (e.g., fillets) and a curved or arcuate transition **614** (e.g., a fillet) between a sealing surface **616** and an inner wall **618** of the body **502**. In some examples, the sealing surface **616** has a profile configured to engage (e.g., for matable engagement with) a profile of the disks **218**. In some examples, the valve seats **220** may be polished (e.g., to less than 16 micro Ra (arithmetic mean roughness), between approximately 5 micro Ra and 25 micro Ra (arithmetic mean roughness), etc.) to improve sealing. Additionally, the second housing portion **206** (e.g., an inner surface of the second housing portion **206** and/or an outer surface of the second housing portion **206** (e.g., defining the stepped surfaces **610**)) may include a radius of curvature or fillet (e.g., a 45 degree fillet) to reduce stress concentrations associated with cyclic loading or vibration.

FIGS. 7A and 7B are a perspective view of the example flow control member **216** of FIGS. 1 and 2. The example flow control member **216** of the illustrated example is a poppet having a body or pylon **702**, a head **704** and the plurality of disks **218**. The pylon **702** of the illustrated example supports the disks **218**. The pylon **702** of the illustrated example has a tapered profile between a first end **706** of the pylon **702** adjacent the head **704** and a second end **708** of the pylon **702** opposite the first end **706**. For example, a dimension (e.g., a radius) of the pylon **702** varies (e.g., continuously or incrementally decreases) between the first end **706** and the second end **708**. However, in some examples, the pylon **702** may include a constant or non-varying diameter between the first end **706** and the second end **708**. The second end **708** of the pylon **702** of the illustrated example includes a cone-shaped end that forms a tip **702a** (e.g., a point). The second end **708** of the illustrated example has a profile (e.g., a sloped or conical profile) that promotes laminar flow characteristics when a fluid flows across the second end **708** of the flow control member **216**.

The flow control member **216** of the illustrated example includes a first disk **710** to engage the first valve seat **604** (FIG. 6), a second disk **712** to engage the second valve seat **606** (FIG. 6), and a third disk **714** to engage the third valve seat **608** (FIG. 6). The first disk **710** of the illustrated example is spaced from the second disk **712** by a first distance D_1 and the second disk **712** is spaced from the third disk **714** by a second distance D_2 . In some examples, the first distance D_1 is equal to the second distance D_2 . In some examples, the first distance D_1 is different than the second distance D_2 . The third disk **714** of the illustrated example is spaced from the head **704** a third distance D_3 . In some examples, the third distance D_3 is equal to the first distance

D_1 and the second distance D_2 . In some examples, the third distance D_3 is different than (e.g., greater than or less than) the first distance D_1 and/or the second distance D_2 . In some examples, the first distance L_1 is different than the first distance D_1 and/or the second distance L_2 is different than the second distance D_2 . In this manner, the first disk **710** may be at a different elevation or offset (e.g., above) relative to the first valve seat **604**, the second disk **712** may be at a different elevation or offset (e.g., above) relative to the second valve seat **606**, and/or the third disk **714** may be at a different elevation or offset (e.g., above) relative to the third valve seat **608**.

Each of the disks **218** of the illustrated example has a central opening **716** and a peripheral edge **718**. The central opening **716** of each of the disks **218** of the illustrated example receives the pylon **702**. In the illustrated example, the central opening **716** defines an inner edge **716a** that is attached to the pylon **702**. To reduce stress concentrations associated with cyclic loading fatigue (e.g., due to pressurization or vibration), a fillet is provided between the inner edge **716a** and the pylon **702**. In the illustrated example, the peripheral edge **718** of the illustrated example includes a curve or arcuate shape to provide a curved lip **720** when the disks **218** are in a non-deflected position. In some examples, the curved or arcuate profile of the peripheral edge **718** provides or improves sealing when the disks **218** engage or seal against the respective valve seats **220**. In some examples, the curved or arcuate profile of the peripheral edge **718** promotes laminar flow characteristics as fluid flows across or past the disks **218**.

Each of the disks **218** of the illustrated example has a first face **722** and a second face **724** opposite the first face **722** separated by a thickness **726** of the disks **218**. The first face **722** provides a sealing surface to engage the valve seats **220**. In some example, the disks **218** and/or the first faces **722** may be polished (e.g., to less than 16 micro Ra (arithmetic mean roughness), between approximately 5 micro Ra and 25 micro Ra, etc.) to improve sealing between the disks **218** and the valve seats **220**. In some examples, the thickness **726** of the disks **218** may affect a cracking pressure of the fluid apparatus **100**. For example, the thickness **726** of the disks **218** affects the cracking pressure of the fluid apparatus **100**. For example, reducing the thickness **726** of the disks **218** reduces cracking pressure and increasing the thickness **726** of the disks **218** increases cracking pressure. The thickness **726** of each of the disks **218** of the illustrated example is the same. In this manner, the example disks **710-714** provide a gradient or varying cracking pressure. For example, the first disk **710** may have a cracking pressure that is greater than the cracking pressure of the second disk **712** and/or the third disk **714**, and the second disk **712** may have a cracking pressure that is greater than the cracking pressure of the third disk **714**. However, in some examples, the thickness **726** of the first disk **710** may be different than the thickness **726** of the second disk **712** and/or the third disk **714**, and/or the thickness **726** of the second disk **712** may be different than the thickness **726** of the first disk **710** and/or the third disk **714**. In some examples, each of the disks **710-714** may have the same cracking pressure. In some examples, the gradient of cracking pressures of the disks **710-714** may be reversed from a lower cracking pressure to a high cracking pressure. For example, the first disk **710** may have a cracking pressure that is less than the cracking pressure of the second disk **712** and/or the third disk **714**, and the second disk **712** may have a cracking pressure that is less than the cracking pressure of the third disk **714**.

The disks **218** of the illustrated example may have different diameters or radii relative to a longitudinal axis **728** of the pylon **702**. For example, the first disk **710** of the illustrated example has a radius that is less than a radius of the second disk **712** and/or the third disk **714**, and the second disk **712** has a radius that is less than the radius of the third disk **714**. For example, the first disk **710** of the illustrated example includes a radius that is slightly less than the radius R_1 of the example first valve seat **604** (FIG. 6), the second disk **712** of the illustrated example includes a radius that is (e.g., slightly) less than the radius R_2 of the example second valve seat **606** (FIG. 6), and the third disk **714** of the illustrated example includes a radius that is (e.g., slightly) less than the radius R_3 of the example third valve seat **606** (FIG. 6). However, in other examples, each of the disks **218** may have the same radius.

The head **704** of the illustrated example couples the flow control member **216** (e.g., the pylon and the disks **218**) to the fluid apparatus **100**. In particular, the annular wall **730** of the illustrated example includes an outer surface having threads **734** to engage the threads **406** of the first housing portion **204** (FIGS. 2 and 4). In some examples, the threads **734** of the head **704** are similar to (e.g., the same as) the threads **406** of the first housing portion **204**. Additionally, as described in greater detail below, to adjust (e.g., increase or decrease) a pre-load to the disks **218**, the flow control member **216** adjusts relative to the longitudinal axis **318** of the first housing portion **204** via the head **704**.

To enable fluid flow through the head **704**, the head **704** of the illustrated example includes an airfoil **736**. More specifically, the airfoil **736** of the illustrated example has a spoke pattern providing a plurality of ribs **738** (e.g., spokes) positioned between a plurality of passageways **740**. The ribs **738** and the passageways **740** of the illustrated example are radially spaced relative to the longitudinal axis **728**. The passageways **740** and the ribs **738** of the illustrated example extend between a first end **742** of the head **704** and a second end **744** of the head **704** opposite the first end **742**. Each of the ribs **738** of the illustrated example separates (e.g., isolates) two adjacent passageways **740**. The ribs **738** provide structural support (e.g., rigidity) to the head **704** and, more generally, to the flow control member **216**. For example, the ribs **738** prevent the flow control member **216** and/or the pylon **702** from twisting about the longitudinal axis **728** during operation. In the illustrated example, the head **704** is cylindrically shaped and has a diameter that is greater than a diameter of the pylon **702**. The head **704** of the illustrated example has a diameter that is larger than the diameter at the first end **706** of the pylon **702**. The ribs **738** of the illustrated example attach the annular wall **730** to an outer surface of the pylon **702**. To promote laminar flow characteristic(s) through the passageways **740**, the ribs **738**, the annular wall **730** and a wall of the pylon **702** of the illustrated example employ an airfoil shape having a curved leading edge and a sharp trailing edge as described in greater detail in FIGS. 8A-8E.

FIG. 8A is a cross-sectional view of one of the passageways **740** of the example head **704** of FIGS. 7A and 7B. Each of the passageways **740** of the head **704** of the illustrated example has an airfoil profile **802**. More specifically, the airfoil profile **802** of the passageways **740** includes a quarter-chord **804** adjacent the first end **742** of the head **704** (e.g., oriented toward the inlet **210** (FIG. 2)) and a trailing edge **806** adjacent the second end **744** of the head **704** (e.g., oriented toward the outlet **212** (FIG. 2)). In particular, the airfoil profile **802** provides or induces laminar fluid flow characteristic(s) and/or prevents or reduces tur-

bulent fluid flow characteristic(s) as fluid flows through the passageways **740**. In other words, the airfoil profile **802** prevents or reduces flow separation from an inner surface **808** of the passageways **740** when fluid flows through each of the passageways **740**. In some examples, one or more of the passageways **740** may include a substantially straight flow path (e.g., a passageway without the airfoil profile **802**) and/or may include any other shape or profile.

FIG. 8B is a partial, perspective view of the example flow control member **216** of FIGS. 1-6, 7A, 7B and 8A. FIG. 8C is another partial, perspective view of the example flow control member **216** of FIGS. 1-6, 7A, 7B and 8A. FIG. 8D is a cross-sectional view of one of the ribs **738** of FIGS. 1-6, 7A, 7B and 8A-8C. Referring to FIGS. 8A-8D, each of the example ribs **738** has a body **810**. The body **810** of each of the ribs **738** of the illustrated example has an airfoil profile **812** (e.g., a gradually narrowing or tapering profile, an aerodynamic profile, etc.) between a first end **814** of the body **810** and a second end **816** of the body **810**. For example, the body **810** of the illustrated example gradually converges toward the second end **816**. For example, the first end **814** has a curved leading edge that converges to a sharp trailing edge at the second end **816**. The first end **814** of the body **810** is oriented toward the inlet **210** (FIG. 2) and is adjacent the first end **742** of the head **704** and the second end **816** of the body **810** is oriented toward the outlet **212** (FIG. 2) and is adjacent the second end **744** of the head **704**. The first end **814** of the body **810** of the illustrated example has a first dimension **818** (e.g., a thickness) that is greater than a second dimension **820** (e.g., a thickness) of the second end **816** of the body **810**. In addition, the first end **814** of the body **810** has an arcuate or curved surface or shape **822**.

FIG. 8E is side view of the example flow control member **216** of FIGS. 1, 2, 7A, 7B and 8A-8C. Referring to FIG. 8E, the first end **814** of the body **810** of each of the rib **738** tapers or is angled between the pylon **702** and the annular wall **730**. For example, a first lateral edge **824** of the body **810** adjacent (e.g., coupled to) the pylon **702** is elevated by a distance **826** (e.g., a vertical distance) relative to a second lateral edge **828** of the body **810** adjacent (e.g., coupled to) the annular wall **730**. In other words, in the orientation of FIG. 8E, the first lateral edge **824** is above or raised relative to the second lateral edge **828**. For example, the first end **814** of the body **810** has a tapered profile **830** between the pylon **702** and the annular wall **730**. In the illustrated example, the second lateral edge **828** terminates at the annular wall **730**. In some examples, the second lateral edge **828** is substantially flush with the first end **742** of the head **704**. Referring to FIGS. 8A-8D, the profile **802** of the passageways **740** and/or the profile **812** of the example ribs **738** of the head **704** of the illustrated example promote laminar flow characteristics and/or prevent formation of turbulent flow characteristics when fluid flows across the head **704** via the passageways **740**.

FIG. 9 is another cross-sectional, perspective view of the example fluid apparatus **100** of FIGS. 1-6, 7A-7B, and 8A-8E. To assemble the example fluid apparatus **100**, the head **704** of the flow control member **216** is coupled to the first housing portion **204** (e.g., via threads). The head **704** of the flow control member **216** couples (e.g., fastens) to the first housing portion **204** via the threads **734** of the annular wall **730** and the threads **406** of the first housing portion **204**.

To provide and/or adjust (e.g., increase or decrease) a pre-load on the disks **218**, the flow control member **216** of the illustrated example adjusts (e.g., rectilinearly) along the longitudinal axis **214**. For example, adjusting a position of the flow control member **216** in a direction along the

longitudinal axis **214** adjusts (e.g., increases or decreases) a compression force imparted to the disks **218**, which causes the disks **218** to impart a sealing force against the respective valve seats **220**. In some examples, the head **704** of the flow control member **216** is rotated about the longitudinal axis **214** and moved to a position corresponding to a desired cracking pressure of the fluid apparatus **100** (e.g., a cracking pressure of the first disk **710**). For example, a position of the head **704** closer toward the inlet **210** provides a greater amount of compression force to the disks **218** to enable the disks **218** to seal tighter against the respective valve seats **220** than a position of the head **704** closer toward the outlet **212**. In some examples, the first disk **710** of the illustrated example may have the smallest surface area and, thus, the head **704** may be positioned to provide a preload associated with the cracking pressure of the first disk **710**. In some examples, due to the threads **734** and the threads **406**, the cracking pressures of the disks **218** can be continuously adjusted between an initial threaded position (e.g., provided at a first end of the threads **406**) and a final threaded position (e.g., provided at a second end of the threads **406** opposite the first end).

A preload (e.g., the compression force provided to the disks **218**) may correspond to a desired cracking pressure (e.g., 90 pounds-per-square-inch (psi)) of the fluid apparatus **100**. In the illustrated example, the cracking pressure may be a minimum upstream pressure at the inlet **210** (FIG. 2) that causes the disks **218** to move to an open position (e.g., the disks **218** deflect away from the respective valve seats **220**) to allow fluid flow between the inlet **210** and the outlet **212** through the fluid flow passageway **208**. Thus, the example fluid apparatus **100** of the illustrated example provides a preload to the flow control member **216** without use of a biasing element such as, for example, a spring. In some examples, a position of the head **704** corresponding to a specific preload may be determined experimentally and/or provided via tables. The experimentally determined preload corresponding to head position may be based on, for example, the thickness **726** of the disks **218**, a radius of the disks, a material of the disks, and/or any other factor(s) or characteristic(s). In some such examples, the head **704** may be rotated about the longitudinal axis **214** to position the head **704** at a specific position that provides the desired preload or cracking pressure.

In some examples, after the head **704** is positioned to provide a desired cracking pressure to the disks **218**, a fastener **902** may be employed to secure a position of the head **704** along the longitudinal axis **214**. For example, the head **704** may be secured to the first housing portion **204** via the fastener **902** to prevent rotation of the head **704** relative to the first housing portion **204** (e.g., the head **704** backing out via the threads **734**) due to, for example, vibration imparted to the fluid apparatus **100** during operation. The fastener **902** may include, for example, a weld-tack, a locking ring, a cryo-locktite, a pin, a chemical fastener (e.g., adhesive), a C-ring, an S-ring, and/or any other lock or fastener to prevent movement or rotation of the head **704** relative to the first housing portion **204** about the longitudinal axis **214**.

After the flow control member **216** is coupled to the first housing portion **204**, the second housing portion **206** is coupled to the first housing portion **204**. When the second housing portion **206** is coupled to the first housing portion **204**, the disks **218** of the flow control member **216** engage the respective valve seats **220**. In some examples, each of the disks **218** matably engages the respective one of the valve seats **220**. In addition, the surface finishes of the sealing

surfaces of the disks **218** and/or the valve seats **220** improve sealing between the disks **218** and the valve seats **220**. In the illustrated example, the fasteners **207** couple the first housing portion **204** and the second housing portion **206** via the flanges **308** and **504**. In the illustrated example, the holes **316** and **512** of the respective flanges **308** and **504** align to receive the fasteners **207**.

In some examples, to trap particulates in a fluid flowing through the fluid apparatus **100**, one or more filters may be positioned in the fluid flow passageway **208**. In some examples, a filter may be positioned adjacent the inlet **210** and/or the outlet **212**. The filter may be, for example, a 10-15 micron filter. In some examples, the filter may be formed with the fluid apparatus **100** (e.g., via injection molding, additive manufacturing, etc.). The filter may span the fluid flow passageway **208** (e.g., across a diameter of the fluid flow passageway **208**). The filter may capture, for example, particulate contained in a fluid and/or particulate that may flake off the disks **218** (e.g., due to the disks **218** fluttering).

Alternatively, in some examples, the first housing **202** does not include the threads **406**. In some such examples, one or more guides or slots are formed in the cavity **402** (e.g., along the inner surface **404**) of the first housing **204** and/or the inner surface **618** of the second housing **206**. In some such examples, the head **704** and/or the flow control member **216** includes one or more rails to slidably engage a respective guide or slot. In some examples, the rails and/or the slots may include a lock (e.g., protrusions, spring-loaded button and opening, a pin and hole configuration, etc.) and/or any other fastener to lock a position of the rails relative to the guides. In some such examples, the lock may be positioned at a plurality of depths or locations (e.g., discrete locations) along the guides and/or the rails. In some such examples, the lock may be positioned at any one of the discrete locations or depths corresponding to a desired preload of the disks **218**. In some such examples, the guide and rail configuration provides a snap-in connection or interface between the flow control member **216** and the first housing **204** and/or the second housing **206**.

Alternatively, in some examples, the flow control member **218** is threaded to the first housing **204** via the threads **406** a fully threaded position (e.g., to a fully upward position in the orientation of FIG. 9). In some such examples, the position of the flow control member **216** provides a preload to the disks **218** when the second housing **206** is coupled to the first housing **204**. A dimensional length of the body **702** (e.g., along the longitudinal axis **728** between the second end **744** of the head **704** and the tip **708** of the body **702**) may be varied during manufacturing to provide different sets of preloads and/or cracking pressures. In some such examples, an array of different sizes of the flow control member **216** may be provided to vary the cracking pressures of the disks **218**. For example, the cracking pressures of the disks **218** may be dependent on a length of the flow control member **216**.

FIG. 10 is a cross-sectional view of the fluid apparatus **100** of FIGS. 1-6, 7A-7B, 8A-8E and 9 shown in a closed position **1000** (e.g., a fully closed position). In operation, when a pressure differential across the disks **218** is less than a cracking pressure of the disks **218**, the disks **218** move to the closed position **1000** (e.g., to seal against the respective valve seats **220**) to prevent fluid flow through the fluid flow passageway **208** from the inlet **210** to the outlet **212**. For example, when a fluid pressure at the inlet **210** is less than a cracking pressure of the disks **218** (e.g., a force or preload imparted to the second end **724** of the disks **218** by the position of the head **704**), the first face **722** of the respective

disks 218 remain engaged or in sealing engagement with the respective valve seats 220 to prevent fluid flow between the inlet 210 and the outlet 212 via the fluid flow passageway 208. In other words, the disks 218 engage the respective valve seats 220 to provide a tight seal (e.g., a leak proof seal) to prevent fluid from flowing or passing across the valve seats 220 when the fluid apparatus 100 is in the closed position 1000. Additionally, the disks 218, in the closed position 1000, prevent fluid from flowing from the outlet 212 toward the inlet 210 (e.g., reverse fluid flow) when, for example, a fluid pressure at the outlet 212 is greater than a fluid pressure at the inlet 210. In other words, the disks 218 provide a tight seal (e.g., a leak proof seal) to prevent reverse fluid flow from the outlet 212 to the inlet 210.

Additionally, the example flow control member 216 provides redundant sealing. In particular, if the first disk 710 fails and allows fluid to flow past the first valve seat 604 when the fluid apparatus 100 is in the closed position 1000, the second disk 712 and/or the third disk 714 remain in sealing engagement with the respective valve seats 606 and 608 when the fluid pressure is less than the cracking pressures of the respective second and third disks 712 and 714, thereby maintaining the fluid apparatus 100 in the closed position 1000.

FIG. 11 is a cross-sectional view of the example fluid apparatus 100 shown in an open position 1100 (e.g., a fully open position). In operation, a pressure differential across the disks 218 that is greater than a cracking pressure of the disks 218 causes the disks 218 to move to the open position 1100 (e.g., move or deflect away from the respective valve seats 220) to allow fluid flow through the fluid flow passageway 208 from the inlet 210 to the outlet 212. More specifically, a fluid pressure at the inlet 210 is greater than a cracking pressure of the first disk 710 (e.g., a fluid pressure imparted to the first face 722 of the first disk 710 that is greater than the preload force imparted to the second face 724 by the flow control member 216) causes the peripheral edge 718 of the first disk 710 to deflect away from the first valve seat 604 to allow fluid flow to flow through an orifice 1102 defined by the first valve seat 604. In the illustrated example, the fluid flows to a first chamber 1104 between the first disk 710 and the second disk 712.

When the fluid reaches the second disk 712, a fluid pressure greater than a cracking pressure of the second disk 712 (e.g., a fluid pressure imparted to the first face 722 of the second disk 712 that is greater than the preload force imparted to the second face 724 of the second disk 712 by the flow control member 216) causes the peripheral edge 718 of the second disk 712 to move or deflect away from the second valve seat 606 to allow fluid flow through an orifice 1106 defined by the second valve seat 606. In the illustrated example, the fluid flows from the first chamber 1104 to a second chamber 1108 between the second disk 712 and the third disk 714. Similarly, when the fluid reaches the third disk 714, a fluid pressure greater than a cracking pressure of the third disk 714 (e.g., a fluid pressure imparted to the first face 722 of the third disk 714 that is greater than the preload force imparted to the second face 724 of the third disk 714 by the flow control member 216) causes the peripheral edge 718 of the third disk 714 to move or deflect away from the third valve seat 608 to allow fluid flow through an orifice 1110 defined by the third valve seat 608 and toward the passageways 740 of the head 704. The fluid then flows to the outlet 212.

In the illustrated example, the disks 218 provide a gradually decreasing cracking pressure from the first disk 710 to the third disk 714. Thus, the fluid apparatus 100 moves to the

open position 1100 when a fluid pressure is greater than a cracking pressure of the first disk 710. In some examples, the disks 218 may be configured to provide a progressive or gradually increasing cracking pressure from the first disk 710 to the third disk 714. In other words, a fluid pressure may cause the first disk 710 and/or the second disk 712 to move to an open position (e.g., deflect away from the respective valve seats 604 and 606), but the fluid pressure may not cause third disk 714 to move to an open position if the fluid pressure is less than a cracking pressure of the third disk 714.

In some examples, when the cracking pressure of the first disk 710 is greater than the cracking pressures of the second disk 712 and the third disk 714, the disks 218 may not move to their respective open positions simultaneously. In some such instances, when fluid enters the first chamber 1104, a pressure of the fluid may decrease to a pressure below the cracking pressure of the second disk 712. Thus, even if the pressure of the fluid upstream from the first disk 710 is greater than a cracking pressure of the second disk 712, the fluid may not cause the second disk 712 to open when the pressurized fluid enters the first chamber 1104 (e.g., due to hysteresis). The second disk 712 may delay opening to an open position until the pressure of the fluid in the first chamber 1104 increases (e.g., recovers) to a pressure above the cracking pressure of the second disk 712. Thus, in some instances, the fluid apparatus 100 may provide a lag or delay in opening the second disk 712 and/or the third disk 714. Such delay may be provided, reduced and/or eliminated by adjusting a characteristic of the fluid apparatus 100 such as, for example, the distances (e.g., vertical distances) between the disks 218 (e.g., distances D1, D2 and D3), the distances (e.g., vertical distances) between the valve seats 220 (e.g., distances L2 and L2), the thicknesses of the disks 218, and/or the diameters of the disks 218. In some instances, however, when the cracking pressure of the first disk 710 is greater than the cracking pressures of the second disk 712 and the third disk 714, the disks 218 may move to their respective open positions simultaneously. In some examples, the characteristic such as, for example, the distances (e.g., vertical distances) between the disks 218 (e.g., distances D1, D2 and D3), the distances (e.g., vertical distances) between the valve seats 220 (e.g., distances L2 and L2), the thicknesses of the disks 218, and/or the diameters of the disks 218 can be adjusted or modified to enable simultaneous movement of the disks 218. In some examples, posts or pillars (e.g., pillars 1632 and 1634 of FIG. 16C) may be employed to enable simultaneous movement of the disks 218.

Additionally, when the peripheral edges 718 of the disks 218 deflect or move away from the respective valve seats 220 (e.g., to an open position), the disks 218 have a curved or arcuate profile (e.g., a smooth curve without a kink or sharp edge). In other words, the arcuate profile provides a continuously smooth surface and does not produce or form a fold or kink in the first face 722 of the disks 218 when the peripheral edge 718 is in a deflected or open position (e.g., spaced or deflected away from the valve seats 220). The relatively smooth or arcuate profile of the disks 218 when deflected away from the respective valve seats 220 promotes laminar flow characteristic(s) and/or prevents formation of turbulent flow as the fluid flows across the first face 722 of the respective disks 218. Additionally, the airfoil profile 802 (FIG. 8A) of the passageways 740 and/or the profile 812 of the ribs 738 (FIG. 8D) may promote laminar flow charac-

teristic(s) and/or prevent formation of turbulent flow characteristic(s) as the fluid flows through the passageways **740** and toward the outlet **212**.

To monitor a characteristic of a fluid flowing through the passageway **208**, the fluid apparatus **100** of the illustrated example employs one or more sensors **1112**. For example, the sensors **1112** may monitor or detect a pressure of a fluid, a temperature of a fluid, a velocity of a fluid, and/or any other characteristic of a fluid flowing through the fluid flow passageway **208**. The sensors **1112** may be positioned within the fluid flow passageway **208** of the fluid apparatus **100**. For example, a first sensor **1112a** may be positioned in the first chamber **1104**, a second sensor **1112b** may be positioned in the second chamber **1108**, a third sensor **1112c** may be positioned upstream from the first valve seat **604**, and/or a fourth sensor **1112d** may be positioned downstream from the third valve seat **608**. The sensors **1112** may include pressure transducers, a piezoelectric sensor and/or any other suitable sensor(s). The sensors **1112** may be formed with or coupled to an inner surface of the fluid flow passageway **208** via, for example, injection molding, additive manufacturing process(es), fasteners (e.g., chemical or mechanical), and/or any other process(es).

FIGS. **12-16** illustrate other example fluid apparatus **1200-1600** disclosed herein. Those components of the example fluid apparatus **1200-1600** that are substantially similar or identical to the components of the example fluid apparatus **100** described above in connection with FIGS. **1-6**, **7A-7B**, **8A-8E**, and **9-11** and that have functions substantially similar or identical to the functions of those components will not be described in detail again below. Instead, the interested reader is referred to the above corresponding descriptions. To facilitate this process, similar reference numbers will be used for like structures.

Referring to FIG. **12**, the example fluid apparatus **1200** includes a valve body **1202** defining a fluid flow passageway **1204** having a plurality of valve seats **1206** between an inlet **1208** and an outlet **1210**. Unlike the housing **202** of the example fluid apparatus **100** of FIGS. **1-6**, **7A-7B**, **8A-8E**, and **9-11**, the valve body **1202** of the example fluid apparatus **1200** is formed as a unitary piece or structure. The flow control member **216** is coupled to the valve body **1202** via the threads **734** of the head **704**. For example, the flow control member **216** is positioned in the fluid flow passageway **208** from the outlet **1210** and fastened to the valve body **1202**.

The example fluid apparatus **1300** of FIG. **13** is shown in a closed position **1301** on the left side of the FIG. **13** and an open position **1303** on the right side of FIG. **13**. The fluid apparatus **1300** of the illustrated example includes a valve body **1302** defining a fluid flow passageway **1304** between an inlet **1306** and an outlet **1308**. An outer surface **1310** of the valve body **1302** includes a first threaded portion **1312** adjacent the inlet **1306** to couple the fluid apparatus **1300** to an upstream source (e.g., the upstream source **102** of FIG. **1**) and a second threaded portion **1314** adjacent the outlet **1308** to couple the fluid apparatus **1300** to a downstream source (e.g., the downstream source **106** of FIG. **1**). The valve body **1302** includes a threaded annular wall **1316** projecting from an inner wall **1318** of the fluid flow passageway **1304**.

A plurality of disks **1320** are positioned in the fluid flow passageway **1304**. In particular, each of the disks **1320** includes an outer peripheral edge **1322** and an inner edge **1324** defined by a center opening **1326**. More specifically, the peripheral edge **1322** is fixed or attached to (e.g., integrally formed with) the inner wall **1318** of the valve body **1302** defining the fluid flow passageway **1304** and the

inner edge **1324** of the disks **1320** is free to deflect or move. The disks **1320** of the illustrated example project from the inner wall **1318** towards a longitudinal axis **1328** of the valve body **1302**. A first disk **1330** has a first dimension (e.g., a diameter), a second disk **1332** has a second dimension (e.g., a diameter) and a third disk **1334** has a third dimension (e.g., diameter), where the first dimension is less than the second dimension and the third dimension, and the second dimension is less than the third dimension.

A poppet or flow control member **1336** is coupled to the valve body **1302** and positioned in the fluid flow passageway **1304**. To couple to the valve body **1302**, the flow control member **1336** of the illustrated example includes a threaded portion **1305** to engage the threaded annular wall **1316**. The flow control member **1336** includes a body **1338** positioned through the center opening **1326** of the respective disks **1320**. In particular, the body **1338** of the example flow control member **1336** includes a conical or stepped profile to define a plurality of valve seats **1340** to be engaged by a respective one of the disks **1320**. For example, the body **1338** of the flow control member **1336** of the illustrated example includes a first valve seat **1342**, a second valve seat **1344**, and a third valve seat **1346** spaced along the body **1338**. The first disk **1330** is to engage or seal against the first valve seat **1342**, the second disk **1332** is to engage or seal against the second valve seat **1344**, and the third disk **1334** is to engage or seal against the third valve seat **1346** when the fluid apparatus is in a closed position to prevent fluid flow from the inlet **1306** to the outlet **1308**.

To support the flow control member **1336** and/or to reduce vibration to the flow control member **1336**, the example fluid apparatus **1300** of the illustrated example includes supports **1348**. The supports **1348** are coupled to or engage (e.g., frictionally engage) the flow control member **1336** to prevent movement or rotation of the body **1338** relative to the longitudinal axis **1328** due to, for example, vibration. The supports **1348** of the illustrated example include passageways **1350** to enable fluid flow through the supports **1348**. In some examples, the passageways **1350** may employ an airfoil profile similar to the passageways **740** of FIGS. **7A** and **7B**.

In some examples, an example valve disclosed herein may be a hybrid or combination of the poppet of FIG. **12** and the valve body of FIG. **13**. For example, a hybrid valve may be configured to provide disks spaced relative to a longitudinal axis of a valve body, where at least a first disk is attached to the valve body and at least a second disk is attached to the poppet. For example, the valve body **1302** of FIG. **13** may be configured with valve seats **1206** to receive the respective disks **218** of the flow control member **216** of FIG. **12**, and the flow control member **216** of FIG. **12** may be configured with valve seats **1340** of FIG. **13** to receive the corresponding disks **1320** of the valve body **1302** of FIG. **13**. Thus, in some such examples, an example fluid apparatus may have one or more disks (e.g., disks **1320**) attached to a valve body that engage valve seats formed by a flow control member, and the fluid apparatus may have one or more disks (e.g., disks **218**) attached to the poppet that engage valve seats formed by the valve body.

Referring to FIG. **14**, the example fluid apparatus **1400** is shown in a closed position **1401** on the left side of FIG. **14** and an open position **1403** on the right side of FIG. **14**. The fluid apparatus **1400** of the illustrated example includes a valve body **1402** having a plurality of disks **1404** (e.g., radially and longitudinally) spaced relative to a longitudinal axis **1406** of a fluid flow passageway **1408**. A flow control member **1410** is supported in the fluid flow passageway

1408 via a first support 1412 adjacent an inlet 1414 and a second support 1416 adjacent an outlet 1418. The first support 1412 and the second support 1416 include passageways 1420 to allow fluid flow through the fluid flow passageway 1408 between the inlet 1414 and the outlet 1418. The flow control member 1410 includes valve seats 1422 to be engaged by the respective disks 1404. In particular, the valve seats 1422 have a varying dimension (e.g., a varying diameter and/or are sloped or angled). In this manner, the disks 1404 seal against the valve seats 1422 when the disks 1404 deflect toward the inlet 1414 to prevent fluid flow through the fluid flow passageway 1408. The disks 1404 deflect away from the valve seats 1422 when the disks 1404 deflect toward the outlet 1418 to allow fluid flow through the fluid flow passageway 1408. Unlike the example fluid apparatus 100, 1200 and 1300 of FIGS. 1-13, the fluid apparatus 1400 of the illustrated example provides a non-adjustable or non-tuning preload to the disks 1404.

Referring to FIG. 15, the example fluid apparatus 1500 is substantially similar to the fluid apparatus 100 of FIGS. 1-11 except the fluid apparatus 1500 does not provide redundant sealing. More specifically, the example fluid apparatus 1500 of the illustrated example includes a valve body 1502 having only one valve seat 1504 and a flow control member 1506 having only one disk 1508.

Referring to FIG. 16A, the example fluid apparatus 1600 is substantially similar to the fluid apparatus 100 of FIGS. 1-11. The example fluid apparatus 1600 of FIGS. 16 includes a housing 1602 having a first housing 1604 (e.g., an upper housing or bonnet) and a second housing 1606 (e.g., a lower housing or valve body). In the illustrated example, the second housing 1606 includes threads 1608 along at least a portion of an inner surface 1610 of the second housing 1606. The threads 1608 are to receive the head 704 of the flow control member 216. In this manner, the flow control member 216 may be positioned or disposed in the second housing 1604 and/or adjusted (e.g., axially adjusted) relative to the second housing 1606 to provide a cracking pressure to the disks 218. Thus, the fluid apparatus 1600 of the illustrated example is similar to the fluid apparatus 100 except that the second housing 1606 includes the threads 1608 and the first housing 1604 does not include threads (e.g., the threads 406 shown in FIG. 4). For example, the second housing 1606 of the illustrated example includes an inlet 210 (e.g., a fitting 508), valve seats 220, a flange 504 and seal glands 520 and 522. The first housing 1604 of the illustrated example includes, for example, a cavity 402, a flange 304, a tapered portion 312, an outlet 212, and a fitting 314. The second housing 1606 of the illustrated example has a length (e.g., an axial length in the direction of the longitudinal axis 214) that is greater than a length of the first housing 1604 (e.g., an axial length in the direction of the longitudinal axis 214). However, in some examples, a length of the first housing 1604 may be greater than or equal to a length of the second housing 1606. The fastener 902 (see FIG. 9) may be provided on the second side of the head 704 to secure a position of the flow control member 216 relative to the second housing 1606 once the flow control member 216 is adjusted to provide a desired cracking pressure. In some examples, the fluid apparatus 1600 of FIG. 16 facilitates placement of the fastener 902 (e.g., a C-ring) to maintain or lock a position of the head 704. In some examples, a spacer may be provided between the respective valve seats 220 (e.g., between the sealing surface of the valve seats 220) and the disks 218 (e.g., the sealing surface of the disks 218) to prevent or reduce abrasion between (e.g., the sealing surfaces of) the valve seats 220 and the disks 218 when the flow

control member 216 rotates relative to the longitudinal axis 214. In some examples, the spacer may be wax or a cloth. After the flow control member 216 is coupled to the second housing 1606, the spacer is removed. For example, the wax may be melted and/or the cloth may be burned after a position of the flow control member 216 is positioned to provide the desired cracking pressures of the disks 218.

FIG. 16B illustrates another example flow control member 1620 disclosed herein that may implement the example fluid apparatus 1600 of FIG. 16A (or any other flow control member of the example fluid apparatus disclosed herein). For example, the flow control member 1620 of FIG. 16B may replace the flow control member 216 of FIG. 16A. The flow control member 1620 is substantially similar to the flow control member 216 of FIGS. 2-6, 7A-7B, 8A-8D and 9-11. For example, the flow control member 1620 includes a pylon 702, a plurality of disks 218 and a head 704. The head 704 of the illustrated example is configured with a tool receiving portion 1622 to receive a tool or other rotating apparatus (e.g., an actuator). The tool receiving portion 1622 of the illustrated example protrudes from an upper surface 1624 of the second end 744 of the head 704 and/or the pylon 702. The tool receiving portion 1622 enables rotation of the head 704 relative to a longitudinal axis 214 (e.g., relative to the second housing 1606). For example, the tool receiving portion 1622 enables rotation of the flow control member 1620 (e.g., via the head 704) to adjust a cracking pressure of the flow control member 216 (e.g., the disks 218). For example, in some instances, a Modulus of Elasticity of the disks 218 may be relatively high such that rotation of the head 704 of one degree relative to the longitudinal axis 214 of the fluid apparatus 1600 may cause a 5-fold increase in the cracking pressure of the disks 218. The tool receiving portion 1622 of the illustrated example enables relatively smaller rotations (e.g., between approximately 0.01 degree and less than 1 degree) of the head 704 relative to the longitudinal axis 214 to enable fine tune adjustment (e.g., small increments of cracking pressure such as 1 pound-per-square-inch (psi)).

The example tool receiving portion 1622 of the illustrated example has a gear profile 1626 to engage a gear face or profile of a tool to enable fine tune adjustment of the flow control member 216. For example, the gear profile 1626 includes gear teeth radially spaced relative to the longitudinal axis 214. In some examples, the tool receiving portion 1622 and/or the second end 744 of the head 704 and/or the pylon 702 may include a Hex profile, a star profile, and/or any other profile to receive a tool (e.g., a Hex key) to enable rotation of the head 704 relative to the longitudinal axis 214. Thus, the example fluid apparatus 1600 of FIG. 16 may facilitate adjustment of the flow control member 216 to adjust a desired cracking pressure.

In some examples, the fluid apparatus 1600 may employ an actuator to move or rotate the fluid control member 216. For example, the actuator may be a rotary actuator, a linear actuator, an electric motor, a pneumatic actuator, a hydraulic actuator and/or any other device to rotate the flow control member 216 about the longitudinal axis 214. In some examples, the actuator may be positioned inside the fluid flow passageway 208. In some examples, the actuator may be coupled externally relative to the fluid apparatus 100. In some examples, the actuator may be a rotary actuator operatively coupled (e.g., via an actuator stem) to the tool receiving portion 1622. In some examples, an actuator may include a linear actuator to move a rack operatively coupled to the gear profile to rotate of the flow control member 216 relative the longitudinal axis 214. In some examples, the

actuator may be an electric motor (e.g., positioned in the fluid flow passageway 208 or outside of the housing 202) that has an output shaft operatively coupled (e.g., directly or indirectly via gears or a transmission) to rotate the flow control member 216. In some such examples, the motor may provide regeneration when a vibration induced rotation causes the flow control member 216 to rotate the motor (e.g., back drive the motor).

FIG. 16C illustrates another example flow control member 1630 disclosed herein that may implement the example fluid apparatus 1600 of FIG. 16A (or any other flow control member of the example fluid apparatus disclosed herein). For example, the flow control member 1630 of FIG. 16C may replace the flow control member 216 of the example fluid apparatus 100 or the example fluid apparatus 1600. The flow control member 1630 is substantially similar to the flow control member 216 of FIGS. 2-6, 7A-7B, 8A-8D and 9-11. For example, the flow control member 1630 includes a pylon 702, a plurality of disks 218 and a head 704. The example flow control member is substantially similar to the flow control member 216 except that it includes legs or pillars 1632 and 1634. The pillars 1632 and 1634 enable simultaneous operation of the disks 218 when the disks 218 move between the open position and the closed position relative to the valve seats 220.

For example, the pillars 1632 of the illustrated example extend between a second side 724 of a first disk 710 and a first side 722 of a second disk 712, and the pillars 1634 of the illustrated example extend between a second side 724 of the second disk 712 and a first side 722 of a third disk 714. In particular, each of the pillars 1632 and 1634 define a longitudinal axis 1636 extending between first end 1638 and a second end 1640. In the illustrated example, the first end 1638 of the pillars 1632 is integrally formed or attached to the second side 724 of the first disk 710 and the second end 1640 is integrally formed or attached to the first side 722 of the second disk 712. Similarly, the first end 1638 of the pillars 1634 is integrally formed or attached to the second side 724 of the second disk 712 and the second end 1640 of the pillars 1634 is integrally formed or attached to the first side 722 of the third disk 714.

The pillars 1632 and 1634 of the illustrated example are radially spaced relative to the longitudinal axis 214. In some examples, the flow control member 1630 may include two pillars 1632 and/or 1634 that are radially spaced relative to the longitudinal axis 214 at an angle of approximately 180 degrees. In some examples, the flow control member 1630 may include three pillars 1632 and/or 1634 that are radially spaced relative to the longitudinal axis 214 at an angle of approximately 120 degrees. In some examples, the flow control member 1630 may include a plurality of pillars 1632 and 1634 that may be radially spaced at an angle of between approximately 30 degrees and 60 degrees relative to the longitudinal axis 214. In some examples, the flow control member 1630 may include only one pillar 1632 and/or 1634.

The longitudinal axis 1636 of the pillars 1632 and/or 1634 of the illustrated example are substantially parallel relative to the longitudinal axis 214. However, in some examples, the pillars 1632 and/or 1634 may be positioned non-parallel (e.g., at an angle greater than zero) relative to the longitudinal axis 214. For example, the longitudinal axis 1636 of the pillars 1632 and/or 1634 may be at a non-parallel angle relative to the longitudinal axis 214. For example, an example angle between the longitudinal axis 1636 of the pillars 1632 and/or 1634 relative to the longitudinal axis 214 may be between approximately 1 degree and 60 degrees.

In operation, the pillars 1632 and 1634 enable simultaneous movement of the first disk 710, the second disk 712 and the third disk 714. In particular, the pillars 1632 and 1634 reduce or eliminate a delay of the first disk 710, the second disk 712 and the third disk 714 moving to their respective open positions due to pressure drops experienced in the chambers 1104 and 1108 noted above in connection with FIG. 11. Thus, the pillars 1632 and 1634 reduce or delay pressure (or flow-rate) change between upstream and downstream sections (e.g., between the chambers 1104 and 1108) of the fluid apparatus 100 by allowing the disks 218 to simultaneously open, as opposed to allowing each chamber 1104 and 1108 to fill with fluid before the third disk 714 moves to an open position.

Thus, when one of the first disk 710, the second disk 712 or the third disk 714 moves to an open position or a closed position relative to the valve seats 220, the other ones of the first disk 710, the second disk 712 or the third disk 714 move simultaneously to their respective open positions or closed positions. For example, when the pressure of the fluid provided at the first side 722 of the first disk 710 is greater than a cracking pressure of the first disk 710, the first disk 710 moves to an open position to allow fluid past the first disk 710. When the first disk 710 moves or deflects to an open position (e.g., an upward position in the orientation of FIG. 16C), the pillars 1632 cause the second disk 712 to deflect or move to an open position, and the pillars 1634 cause the third disk 714 to deflect or move to an open position. Similarly, when the first disk 710 moves to a closed position relative to the valve seat 220, the second disk 712 and the third disk 714 also move to the closed position relative to their respective valve seats 220.

FIG. 16D illustrates another example flow control member 1650 disclosed herein that may implement the example fluid apparatus 1600 of FIG. 16A (or any other flow control member of the example fluid apparatus disclosed herein). For example, the flow control member 1650 of FIG. 16D may replace the flow control member 216 of the example fluid apparatus 100 or the example fluid apparatus 1600. The flow control member 1650 is substantially similar to the flow control member 1630 of FIG. 16C, but formed with different pillars 1652 and 1654. In particular, the pillars 1652 and 1654 of the illustrated example have a varying flexibility or stiffness characteristic(s). For example, the pillars 1652 and 1654 have a first flexibility or stiffness characteristic and a second flexibility or stiffness characteristic different than the first flexibility or stiffness characteristic. For example, the pillars 1652 and 1654 are relatively flexible when disks 218 are in the closed position (e.g., sealingly engaged with the valve seats 220) and are relatively stiff when the disks crack toward the open position. For example, the pillars 1652 and 1654 increase in stiffness during compression of the pillars 1652 and 1654 such that the disks 218 are more flexible than the pillars 1652 and 1654 when the disks 218 move or deflect toward the open position (e.g., move away from the valve seats 220). As a result, the first flexibility or stiffness characteristic of the example pillars 1652 and 1654 compensate for machining or manufacturing tolerances or errors between the disks 218 (e.g., distances D1, D2 and D3 in FIG. 7A) and the valve seats 220 (e.g., distances L1, L2 and L3 in FIG. 6). In other words, the first flexibility characteristic of the pillars 1652 and 1654 compensate for a small differential in distance offset errors or tolerances between the disks 218 and/or the valve seats 220 (e.g., vertical distances). However, the second flexibility characteristic provides sufficient stiffness during a large offset in distances (e.g., during cracking of the first disk 710) to cause the disks

218 to simultaneously move to their respective open positions relative to the valve seats 220.

To provide varying compression and/or stiffness to the pillars 1652 and 1654, the pillars 1652 and 1654 of the illustrated example are bent, curved or bowed between a first end 1658 and a second end 1660 of the respective pillars 1652 and 1654. More specifically, each of the pillars 1652 and 1654 of the illustrated example include a pair of bows or structures 1662 (e.g., a first bow 1662a and a second bow 1662b having an arcuate profile). As the pair of bows 1662 compress, a center section 1664 of each pair of bows 1662 becomes closer and, ultimately touch, thereby preventing further compression of the pair of bows 1662 and increasing the stiffness of the pillars 1652 and 1654. As a result, the increase in stiffness causes the pillars 1652 and 1654 to exert an upward force, causing the disks 218 to move simultaneously when the first disk 710 moves relative to the valve seat 220.

The pillars 1632 and/or 1634 of the example flow control member 1630, the pillars 1652 and/or 1654 of the example flow control member 1650, and/or the tool receiving portion 1622 of the example flow control member 1620 may be implemented with the other example flow control member s 218, 1320, 1404 and 1508 disclosed herein.

FIG. 17 illustrates an example method 1700 that may be used to manufacture, fabricate and/or assemble an example fluid apparatus disclosed herein such as the example fluid apparatus 100, 1200, 1300, 1400, 1500 and/or 1600 of FIGS. 1-6, 7A-7B, 8A-8E, and 9-16. FIG. 18 illustrates an example method 1800 that may be used to assemble an example fluid apparatus disclosed herein such as the example fluid apparatus 100, 1200, 1300, 1400, 1500 and/or 1600 of FIGS. 1-6, 7A-7B, 8A-8E, and 9-16. FIG. 19 illustrates an example method 1900 of operation of an example fluid apparatus disclosed herein such as the example fluid apparatus 100, 1200, 1300, 1400, 1500 and/or 1600 of FIGS. 1-6, 7A-7B, 8A-8E, and 9-16.

While an example manner of manufacturing, assembling and/or operating the example fluid apparatus 100, 1200, 1300, 1400, 1500 and/or 1600 has been illustrated in FIGS. 17, 18 and 19, one or more of the steps and/or processes illustrated in FIGS. 17, 18 and 19 may be combined, divided, re-arranged, omitted, eliminated, modified and/or implemented in any other way. Further still, the example methods of FIGS. 17, 18 and 19 may include one or more processes and/or steps in addition to, or instead of, those illustrated in FIGS. 17, 18 and 19, and/or may include more than one of any or all of the illustrated processes and/or steps. Further, although the example method is described with reference to the flowcharts illustrated in FIGS. 17, 18 and 19, many other methods of manufacturing, assembling and/or operating the example fluid apparatus 100, 1200, 1300, 1400, 1500 and/or 1600 of FIGS. 1-6, 7A-7B, 8A-8E, and 9-16 may alternatively be used.

Referring to FIG. 17, the example method 1700 disclosed herein may begin by forming a first housing portion (block 1702), forming a second housing portion (block 1704), and forming a flow control member (block 1706). In some examples, the second housing portion may be formed with one or more valve seats. In some examples, the flow control member may be formed with one or more disks. In some examples, the example fluid apparatus 100, 1200, 1300, 1400, 1500 and/or 1600 disclosed herein may be configured with only one disk, two disks and/or more than three disks, respectively. In some examples, the example fluid apparatus 100, 1200, 1300, 1400, 1500 and/or 1600 disclosed herein may be manufactured or formed via an additive manufac-

turing process (e.g., 3D printing), injection molding, machining, and/or any other suitable manufacturing process, and/or any combination thereof. Example additive manufacturing process(es) include, but are not limited to, direct metal laser sintering (DMLS), laser freeform manufacturing technology (LFMT), selective laser melting (SLM), fused deposition modeling (FDM), laser puddle deposition (LPD), small puddle deposition (SPD), laser powder bed (LPB), electron beam powder bed (EBPD), indirect power bed (IPD), laser deposition technology (LDT), laser repair technology (LRT), laser cladding technology (LCT), laser deposition welding (LDW), laser deposition welding with integrated milling (LDWM), selective laser sintering (SLS), direct metal printing (DMP), and/or stereolithography (SLA) and/or any combination.

For example, the first housing portion 204, second housing portion 206, the valve body 1202, 1302, 1402, 1502, 1602, the disks 218, 1320, 1404, 1508 and/or the flow control member 216, 1336, 1410, 1506 of the illustrated examples may be manufactured using an additive manufacturing process (e.g., direct metal laser sintering or 3D printing). In some examples, the fluid apparatus 100 may be formed in an assembled state via, for example, additive manufacturing. In some examples, the first housing portion 204, 1604, the second housing portion 206, 1606, and/or the valve body 1202, 1302, 1402, 1502 may be formed via, for example, injection molding and the flow control member 216, 1336, 1410, 1506 may be formed via additive manufacturing process(es), or vice versa. In some examples, the flow control member 216, 1336, 1410, 1506 may be formed with molten Teflonor Kel-F material via injection molding.

In some examples, some or all of the threads (e.g., the threads 406, 734, 1608 the threads of the fittings 314 and 510, etc.) of the example fluid apparatus 100, 1200, 1300, 1400, 1500 and/or 1600 disclosed herein (e.g., the first housing portion 204, 1604 second housing portion 206, 1606, the valve body 1202, 1302, 1402, 1502, the disks 218, 1320, 1404, 1508 and/or the flow control member 216, 1336, 1410, 1506) may be formed via additive manufacturing process(es). In some examples, the threads 406, 734, 1608 and/or the threads of the fluid apparatus 100, 1200, 1300, 1400, 1500 and/or 1600 disclosed herein may be sized as 2.000-12-UNC threading, or a range of course or fine threading sizes. In some examples, the threads 406, 734, 1608 and/or the threads of the fluid apparatus 100, 1200, 1300, 1400, 1500 and/or 1600 may be power screws (e.g., a Joyce worm-gear screw jack). Example power screws are provided by J. K. Nisbett and R. G. Budynas, Shigley's Mechanical Engineering Design, "The Mechanics of Power Screws", chapter 8, section 2, 9th edition. In some examples, the threads (e.g., threads 406, 734, 1608, the threads of the fittings 314 and 510) may be formed as a secondary process.

In some examples, after formation of the flow control member 216, 1336, 1410, 1506, the disks 218, 1320, 1404, 1508, and/or the valve seats 220, 1206, 1340, 1422, and 1504, the disks 218, 1320, 1404, 1508 and/or the valve seats 220, 1206, 1340, 1422 and/or 1504 may be polished via a secondary process. For example, a lapping process may be employed on the first side 722 of the disks 218 and/or the valve seats 220, 1206, 1340, 1422 and/or 1504 to allow for localized polishing to improve sealing (e.g., improve sealing classification). Additionally, in some examples, to reduce stress concentrations associated with cyclic loading or vibration, inner and/or outer surfaces of the example the example fluid apparatus 100, 1200, 1300, 1400, 1500 and/or 1600 disclosed herein may include a radius of curvature or fillet (e.g., a 45 degree fillet) to reduce pointed or sharp edges

and/or to provide smooth transitions between differently dimensioned portions of the fluid apparatus. For example, inner and/or outer surfaces of the first housing portion **204**, the second housing portion **206** (e.g., an inner surface of the second housing portion **206** and/or an outer surface of the second housing portion **206** (e.g., defining the stepped surfaces **610**)), and/or the flow control member **216** may include a radius of curvature or fillet (e.g., a 45 degree fillet) to reduce pointed or sharp edges.

Additionally, the components of the example fluid apparatus **100**, **1200**, **1300**, **1400**, **1500** and/or **1600** disclosed herein may be formed from the same material or different material(s). For example, the first housing portion **204**, **1604**, second housing portion **206**, **1606**, the valve body **1202**, **1302**, **1402**, **1502**, the disks **218**, **1320**, **1404**, **1508** and/or the flow control member **216**, **1336**, **1410**, **1506** of the illustrated examples may be composed of Inconel **625**, metal, aluminum, plastic, Polytetrafluoroethylene (PTFE), stainless steel, an alloy and/or any other suitable material for use in, for example, propulsion systems, cryogenic applications, hydraulic systems, and/or any other material(s) or alloy. In sonic examples, the first housing portion **204**, **1604**, second housing portion **206**, **1606**, the valve body **1202**, **1302**, **1402**, **1502** may be formed of a first material, the disks **218**, **1320**, **1404**, **1508** may be formed of a second material, and/or the flow control member **216**, **1336**, **1410**, **1506** may be formed of a third material. In some examples, the first material is the same as the second material and/or the third material. In some examples, the second material is the same as the third material. In some examples, the first material is different from the second material and/or the third material. In some examples, the second material is different than the first material. In some examples, the disks **218**, **1320**, **1404**, **1508** are formed of different materials. In some examples, the flow control member **216**, **1336**, **1410**, **1506** may be formed (e.g., grown) with a Functionally Graded Materials process (e.g., an FGM process) such that a gradient of coefficient of thermal expansion (CTE) across the flow control member **216**, **1336**, **1410**, **1506** provides varying cracking-pressure gradients across the disks **218**, **1320**, **1404** (e.g., across the three disks **710**, **712**, **714**) with changes in temperatures, which may be useful for re-entry vehicles, passing multiple sonic regimes, or space vehicles that are periodically eclipsed from the sun by the earth. In some examples, the disks **218**, **1320**, **1404** may be formed with material(s) having a coefficient of thermal expansion (e.g., Kel-F) that varies the cracking pressures of the disks **218** (e.g., the first disk **710**, the second disk **712** and/or the third disk **714**), **1320**, **1404**, based on a temperature to provide a continuum of cracking pressures during, for example, sonic and/or thermal regimes. For example, materials having a relatively high coefficient of thermal expansion may cause the cracking pressures of the disks **218**, **1320**, **1404** to vary based on a temperature of a process fluid flowing through the fluid apparatus **100** and/or a temperature of the environment surrounding the valve apparatus **100**. In some examples, the disks **218**, **1320**, **1404** may be composed of material(s) having a low coefficient of thermal expansion such that temperature of the process fluid and/or the environment surrounding the fluid apparatus **100** does not affect the cracking pressures of the disks **218**, **1320**, **1404**. In this manner, the fluid apparatus disclosed herein may provide different performance characteristics during different portions of a flight mission. For example, the cracking pressures of the disks **218** may be a first cracking pressures during an

ascent envelope of a mission and a second cracking pressure different than the first cracking pressure during a descent envelope of a mission.

Additionally, the example flow control member **216**, **1336**, **1410**, **1506** disclosed herein may be a unitary piece or structure. However, in some examples, the disks **218** or the disk **1508** may be formed separately from the pylon **702** of the flow control member **216** or **1506**. In some examples, the disks **218** or the disk **1508** may be formed from a first material different from a material of the pylon **702**. In some examples, the disks **218** or the disk **1508** may be coupled or attached to the pylon **702**. For example, the disks **218** or the disk **1508** may attach to the pylon via fasteners (e.g., mechanical fasteners, chemical fasteners), shrink fit and/or any other process(es). In some examples, the example fluid apparatus **1200**, **1300**, **1400**, **1500** and/or **1600** disclosed herein (e.g., the first housing portion **204**, **1604**, second housing portion **206**, **1606**, the valve body **1202**, **1302**, **1402**, **1502**, the disks **218**, **1320**, **1404**, **1508** and/or the flow control member **216**, **1336**, **1410**, **1506**) may be coated (e.g., sprayed) with an anti-tarnishing material(s) to prevent corrosion of the fluid apparatus **1200**, **1300**, **1400**, **1500** and/or **1600** during non-use conditions.

Referring to FIG. **18**, the method **1800** of the illustrated example includes coupling the flow control member to the first housing portion (block **1802**). For example, referring to FIG. **9**, the example flow control member **216** is coupled to the first housing portion **204** or **1604** via the head **704**. A position of the flow control member is adjusted relative to the first housing portion to provide a preload to the disks (block **1804**). For example, referring to FIG. **9**, the head **704** of the flow control member **216** is rotated about the longitudinal axis **214** to a desired position that provides a desired preload to the disks **218**. In particular, the threads **734** of the head **704** engage the threads **406** of the first housing portion **204** to enable rectilinear adjustment of the flow control member **216** along the longitudinal axis **214**. Once the head **704** or the flow control member **216** is at a desired position, a fastener **902** may be provided to maintain the position of the head **704** or the flow control member **216** relative to the first housing portion **204**.

The first housing portion is then coupled to the second housing portion to define a fluid flow passageway between an inlet and an outlet (block **1806**). For example, referring to FIG. **9**, the first housing portion **204** is coupled to the second housing portion **206** via the respective flanges **308** and **504** and the fasteners **207**. In some examples, the first housing portion **204** and the second housing portion **206** of FIGS. **1-6**, **7A-7B**, **8A-8E**, and **9-11**, FIG. **15** and/or of FIG. **16** may be formed without the flanges **308** and **504**. In some such examples, the first housing portion **204**, **1604** may be coupled to the second housing portion **206**, **1606** via welding (e.g., linear friction welding, heat welding, fusion), a clamp, rivets, threads, and/or any another fastener (e.g., mechanical fastener, a chemical fastener, etc.). Absent the flanges **308** and **504**, the fluid apparatus **100**, **1500** and **1600** may provide a relatively smaller footprint. For example, an outermost portion of an outer surface of the first housing portion **204**, **1604** may be substantially flush with an outermost portion of an outer surface of the second housing portion **206**, **1606** (to provide a cylindrical profile). Referring to FIGS. **12-14**, the portion of the method represented by block **1806** may be omitted when manufacturing, forming or assembling the example fluid apparatus **1200-1400**.

Referring to FIG. **19**, the method **1900** of the illustrated example begins by receiving a fluid having a first pressure at an inlet of a valve (block **1902**). For example, a fluid is

received at the inlet 210 from the upstream source 102. The method 1900 includes enabling the fluid at the inlet to flow past a first disk positioned between the inlet and a first chamber of a fluid flow passageway when the first pressure is greater than a first cracking pressure of the first disk (block 1904). For example, the fluid at the inlet 210 flows past the first disk 710 to the first chamber 1104. For example, when the fluid at the inlet 210 is greater than a first cracking pressure of the first disk 710, the peripheral edge 718 of the first disk 710 deflects or moves away from the valve seat 604 to allow the fluid to flow to the first chamber 1104. For example, the first chamber 1104 is positioned between the inlet 210 and the second disk 712. In the example shown in FIG. 15, the fluid flows to the outlet 212 after the first disk 710 moves to the open position. In some examples, the fluid flows to the second chamber 1108 when the first disk 710 moves to the open position.

In some examples, fluid in a first chamber is enabled to flow past a second disk positioned between the first chamber and the second chamber of the fluid flow passageway when a second pressure of the fluid in the first chamber is greater than a second cracking pressure of the second disk (block 1906). For example, the fluid in the first chamber 1104 flows past the second disk 712 and to the second chamber 1108 when the pressure of the fluid in the first chamber 1104 is greater than the second cracking pressure of the second disk 712. For example, when the pressure of the fluid in the first chamber 1104 is greater than the cracking pressure of the second disk 712, the peripheral edge 718 of the second disk 712 deflects or moves away from the second valve seat 606 to allow the fluid to flow to the second chamber 1108.

In some examples, the fluid in the second chamber is enabled to flow to an outlet of the fluid flow passageway when a pressure of the fluid in the second chamber is greater than a third cracking pressure of a third disk (block 1908). For example, the fluid in the second chamber 1108 flows past the third disk 714 when the pressure of the fluid in the second chamber 1108 is greater than the third cracking pressure of the third disk 714. For example, when the pressure of the fluid in the second chamber 1108 is greater than the cracking pressure of the third disk 714, the peripheral edge 718 of the third disk 714 deflects or moves away from the third valve seat 608 to allow the fluid to flow to the outlet 212.

In some examples, the first cracking pressure of the first disk 710, the second cracking pressure of the second disk 712 and/or the third cracking pressure of the third disk 714 is determined by the position of the flow control member 216 relative to the first housing 202 or the second housing 204. In some examples, the first cracking pressure is different than the second cracking pressure and/or the second cracking pressure is different than the third cracking pressure. In some examples, the first cracking pressure is equal to the second cracking pressure and/or the third cracking pressure.

In some examples, in operation, a vibrational force imparted to the disks 218, 132, 1404, 1508 that is equal to a resonant frequency of the disks 218, 132, 1404, 1508 may cause the disks 218, 132, 1404, 1508 to flake and cause debris to flow downstream. To ensure an aeroelastic, flutter-free design and/or to prevent or reduce flacking of the disks 218, 132, 1404, 1508, the disks 218, 132, 1404, 1508 may be tested after formation of the flow control member 216, 1336, 1410, 1506. For example, the fluid apparatus 100, 1200, 1300, 1400, 1500 and/or 1600 may be tested with conditions or fluid characteristics that the fluid apparatus 100, 1200, 1300, 1400, 1500 and/or 1600 may experience

during operation. For example, during testing, the vibrational frequencies of the disks 218, 132, 1404, 1508 may be measured or determined and compared to the resonant frequency of the respective disks 218, 132, 1404, 1508. If the measured frequency is equal to the resonant frequency, a characteristic of the fluid apparatus 100, 1200, 1300, 1400, 1500 and/or 1600 such as, for example, the distances (e.g., vertical distances) between the disks 218, 132, 1404, 1508 (e.g., distances D1, D2 and D3), the distances (e.g., vertical distances) between the valve seats 220, 1340, 1422, 1504 (e.g., distances L2 and L2), the thicknesses of the disks 218, 132, 1404, 1508, and/or the diameters of the disks 218, 132, 1404, 1508, etc., may be adjusted, altered, and/or modified (e.g., redesigned) to alter the resonant frequency of the disks 218, 132, 1404, 1508.

In some examples, a wall thickness of the example fluid apparatus 100, 1200, 1300, 1400, 1500 and/or 1600 disclosed herein (e.g., the first housing portion 204, 1604 the second housing portion 206, 1606 and/or the valve body 1202, 1302, 1402, 1502) may be configured (e.g., dimensionally sized) using the following Soderberg Equations 1-6:

$$\frac{\sigma_a}{S_e} + \frac{\sigma_m}{S_y} = \frac{1}{n} \tag{Eq. 1}$$

$$\sigma_a = \frac{Pd}{2t} \tag{Eq. 2}$$

$$n = 2 \text{ (safety factor)} \tag{Eq. 3}$$

$$\sigma_m = \sigma_a/2 \tag{Eq. 4}$$

$$\frac{\sigma_a}{2} \left(\frac{2}{S_e} + \frac{1}{S_y} \right) = \frac{1}{n} \tag{Eq. 5}$$

$$t = n(P) \left(\frac{d}{4} \right) \left(\frac{2}{S_e} + \frac{1}{S_y} \right) \tag{Eq. 6}$$

where: σ_a is amplitude stress; S_e is endurance limit from Marin Equation; σ_m is midrange stress; S_y is yield strength; n is factor of safety; S_e' is test specimen endurance limit;

S_{ut} is ultima strength; where the k_a - k_f values are obtained from marine K value equations;

k_a is surface condition modification factor; k_b is size factor

k_c is loading factor;

k_d is temperature factor; k_e is reliability factor;

k_f is miscellaneous—effects factor;

and t is thickness.

For example, a wall thickness of the first housing portion 204 and/or the second housing portion 206 of FIGS. 1-11, made from material Inconel 625, configured to have a maximum pressure rating of 100 psi, provides a thickness of 0.4100 inches as follows:

$$S_y = 40 \times 10^3 \text{ psi} \tag{Eq. 7}$$

$$S_e' = 20 \times 10^3 \text{ psi} \tag{Eq. 8}$$

$$S_{ut} = 100 \times 10^3 \text{ psi} \tag{Eq. 9}$$

$$k_a = a(S_{ut})^b = 2.7(100 \times 10^3)^{-0.265} = 0.128 \tag{Eq. 10}$$

$$k_b = 0.91 d^{-1.57} = 0.732 \tag{Eq. 11}$$

$$k_c = 0.85 \text{ (axial)} \tag{Eq. 12}$$

-continued

$$k_d = 1 \text{ (cryo)} \quad \text{Eq. 13}$$

$$k_e = 0.620 @ 99.9999\% \text{ Reliability} \quad \text{Eq. 14}$$

$$k_f = 1 \quad \text{Eq. 15}$$

$$S_e = S'_e(k_a)(k_b)(k_c)(k_d)(k_e)(k_f) \quad \text{Eq. 16}$$

$$S_e = (20 \times 10^3)(0.128)(0.732)(0.85)(1)(0.620)(1) = 987.56$$

$$t = 2(100) \left(\frac{4}{4} \right) \left(\frac{2}{987.56} + \frac{1}{40 \times 10^3} \right) = 0.4100 \text{ inches} \quad \text{Eq. 17}$$

In some examples, the wall thickness of the example fluid apparatus **100**, **1200**, **1300**, **1400**, **1500** and/or **1600** disclosed herein (e.g., the first housing **204**, **1604** and/or the second housing **206**, **1604**) may be determined using Finite Element Analysis doublet-lattice solver. In some examples, the wall thickness of the example fluid apparatus **100**, **1200**, **1300**, **1400**, **1500** and/or **1600** disclosed herein (e.g., the first housing and/or second housing) may be verified using the following wall-thickness equation:

$$\sigma_a = \frac{P_i R_i^2 - P_o R_o^2 - R_i^2 R_o^2 (P_o - P_i)}{R_o^2 - R_i^2}; \quad \text{Eq. 17}$$

where, σ_a is largest at $R=R_i$; P_i is an outer pressure; P_o is an outer pressure; R_i is an inner radius (i.e., the radius between the longitudinal axis and the inner surface of the first housing or the second housing), R_o is an outer radius (i.e., the radius between the longitudinal axis and the outer surface of the first housing or the second housing); and R is the location to determine stress.

The fasteners **207** may be tightened in a star pattern to facilitate a seal between the flanges **308** and **504** (e.g., evenly distribute load across a circumference of the seals). In some examples, the fasteners **207** may be pre-loaded with a specific torque. In some examples, safety wires, lock-nuts, Loctite® and/or any other fastener may be employed to ensure pre-loading in the presence of vibration. In some examples, bolt torque pre-loading of the fasteners **207** may be determined with the following equations:

$$T=K*F_i*d \quad \text{Eq. 18:}$$

$$K=0.2 \quad \text{Eq. 19:}$$

$$F_i=0.75*F_p \quad \text{Eq. 20:}$$

$$F_p=A_t*S_p \quad \text{Eq. 21:}$$

$$S_p=0.85*S_y \quad \text{Eq.22:}$$

where, T is torque; F_i is preload; K is torque coefficient; d is major diameter; F_p is proof load; S_p is proof strength, A_t is tensile-stress area; and S_y is yield strength. For example, a major diameter of 0.25 inches, a tensile-stress area of 0.0318, a yield strength of 92 kpsi, a proof strength of 0.85(92 kpsi), and a torque coefficient of 0.2 would require a torque of 7.77 ft-lb.

$$A_t=0.0318$$

$$S_y=92 \text{ kpsi}$$

$$F_p=(0.0318)(0.85)(92*10^3)$$

$$F_i=(0.75) (0.0318)(0.85)(92*10^3)$$

$$T=(0.2) (0.75) (0.0318)(0.85)(92*10^3)(0.25)^{1/2}$$

$$T=7.77 \text{ ft-lb}$$

Disk deflection of the disks **218**, **1320**, **1404** and/or **1508** may be determined via Roark's equations. For example, deflection of a disk having an outer free edge and an inner fixed edge may be determined from the following equations:

$$M_{rb} = \frac{-qa^2}{C_8} \left[\frac{C_9}{2ab} (a^2 - r_0^2) - L_{17} \right] \quad \text{Eq. 23}$$

$$Q_b = \frac{q}{2b} (a^2 - r_0^2) \quad \text{Eq. 24}$$

$$v_a = M_{rb} \frac{a^2}{D} C_2 + Q_b \frac{a^3}{D} C_3 - \frac{qa^4}{D} L_{11} \quad \text{Eq. 25}$$

$$\theta_a = M_{rb} \frac{a}{D} C_5 + Q_b \frac{a^2}{D} C_6 - \frac{qa^3}{D} L_{14} \quad \text{Eq. 26}$$

$$C_2 = \frac{1}{4} \left[1 - \left(\frac{b}{a} \right)^2 \left(1 + 2 \ln \frac{a}{b} \right) \right] \quad \text{Eq. 27}$$

$$C_3 = \frac{b}{4a} \left\{ \left[\left(\frac{b}{a} \right)^{23} + 1 \right] \ln \frac{a}{b} + \left(\frac{b}{a} \right)^2 - 1 \right\} \quad \text{Eq. 28}$$

$$C_8 = \frac{1}{2} \left[1 + \nu + (1 - \nu) \left(\frac{b}{a} \right)^2 \right] \quad \text{Eq. 29}$$

$$C_9 = \frac{b}{a} \left\{ \frac{1 + \nu}{2} \ln \frac{a}{b} + \frac{1 - \nu}{4} \left[1 - \left(\frac{b}{a} \right)^2 \right] \right\} \quad \text{Eq. 30}$$

$$L_{11} = \frac{1}{64} \left\{ 1 + 4 \left(\frac{r_o}{a} \right)^2 - 5 \left(\frac{r_o}{a} \right)^4 - 4 \left(\frac{r_o}{a} \right)^2 \left[2 + \left(\frac{r_o}{a} \right)^2 \right] \ln \frac{a}{r_o} \right\} \quad \text{Eq. 31}$$

$$L_{17} = \frac{1}{4} \left\{ 1 - \frac{1 - \nu}{4} \left[1 - \left(\frac{r_0}{a} \right)^4 \right] - \left(\frac{r_0}{a} \right)^2 \left[1 + (1 + \nu) \ln \frac{a}{r_0} \right] \right\} \quad \text{Eq. 32}$$

where:

$$y_b=0$$

$$\theta_b=0$$

$$M_{ra}=0$$

$$Q_a=0$$

and, where the K values are provided from table 1.

TABLE 1

b/a	0.1	0.3	0.5	0.7	0.9
K_{y_a}	-0.0757	-0.0318	-0.0086	-0.0011	
K_{θ_a}	-0.0868	-0.0512	-0.0207	-0.0046	-0.00017
$K_{M_{rb}}$	-0.9646	-0.4103	-0.1736	-0.0541	-0.00530

Stress-strain relationship of the disks **218**, **1320**, **1404** and/or **1508** may be determined via Roark's equations. For example, stress or strain of a disk having an outer free edge and an inner fixed edge may be determined from the following equations:

$$\sigma = \frac{6M}{t^2} \quad \text{Eq. 33}$$

where σ is stress, M is moment, and t is disk thickness. Equation 33, for example, can be used to determine maximum stress on the disks **218**, **1320**, **1404** and/or **1508** where the disks attach to the pylon **702**. The plate constant D can be obtained from the following equation:

$$D = \frac{Et^3}{12(1-\nu^2)}; \quad \text{Eq. 34}$$

where D is the plate constant, E is the modulus of elasticity, t is the disk thickness, and ν is Poisson's ratio.

Although certain example apparatus and methods have been described herein, the scope of coverage of this patent is not limited thereto. On the contrary, this patent covers all methods, apparatus and articles of manufacture fairly falling within the scope of the amended claims either literally or under doctrine of equivalents.

What is claimed is:

1. A fluid apparatus comprising:
 - a housing defining a fluid flow passageway between an inlet and an outlet, the housing having a first valve seat and a second valve seat positioned in the fluid flow passageway, the first valve seat being spaced from the second valve seat; and
 - a flow control member positioned in the fluid flow passageway, the flow control member including a first disk and a second disk coupled to a pylon of the flow control member, the first disk to engage the first valve seat and the second disk to engage the second valve seat, the first disk includes a first inner edge and a first peripheral edge, the first inner edge being fixed to the pylon, the first peripheral edge to deflect relative to the first valve seat to allow or prevent fluid flow through the fluid flow passageway, the pylon and the first inner edge remain stationary when the first peripheral edge moves relative to the first valve seat, the flow control member being adjustable relative to the housing to adjust cracking pressures of the respective first and second disks.
2. The apparatus of claim 1, wherein the housing includes an inner surface having a first stepped surface to define the first valve seat and a second stepped surface to define the second valve seat.
3. The apparatus of claim 1, where in the second disk includes a second inner edge and a second peripheral edge, the second inner edge being fixed to the flow control member, the second peripheral edge to deflect relative to the second valve seat to allow or prevent fluid flow through the fluid flow passageway, the pylon and the second inner edge remain stationary when the second peripheral edge moves relative to the second valve seat.
4. The apparatus of claim 3, wherein the first disk includes a central opening to define the first inner edge, the central opening to receive the pylon of the flow control member.
5. The apparatus of claim 3, wherein the first peripheral edge includes a curved profile.
6. The apparatus of claim 5, wherein the first valve seat includes a curved profile to matably engage the curved profile of the first peripheral edge.
7. The apparatus of claim 1, wherein the cracking pressures of the first and second disks are equal.
8. A fluid apparatus comprising:
 - a housing defining a fluid flow passageway between an inlet and an outlet, the housing having a first valve seat and a second valve seat positioned in the fluid flow passageway, the first valve seat being spaced from the second valve seat; and
 - a flow control member positioned in the fluid flow passageway, the flow control member including a first disk and a second disk, the first disk to engage the first valve seat and the second disk to engage the second valve seat, a position of the flow control member being

adjustable along a longitudinal axis of the flow control member to provide a preset load to the disks.

9. The apparatus of claim 8, wherein the flow control member includes a threaded portion to engage a threaded wall of the housing to enable adjustment of the flow control member in a direction along the longitudinal axis.

10. An apparatus comprising:

a housing defining a valve seat positioned in a fluid flow passageway between an inlet and an outlet; and
 a flow control member positionable in the fluid flow passageway, the flow control member including:
 a body;

a disk coupled to the body, the disk having a center portion coupled to the body and a peripheral edge extending from the center portion; and

a head portion to couple the flow control member to the housing, the head portion including a plurality of passageways to allow fluid flow between a first side of the head oriented toward the inlet and a second side of the head oriented toward the outlet, each of the passageways of the head including an airfoil profile.

11. The apparatus of claim 10, wherein the peripheral edge of the disk is to seal against the valve seat to prevent fluid flow through the fluid flow passageway when a pressure at an inlet of the housing is less than a cracking pressure of the disk, and the peripheral edge is to move away from the valve seat to allow fluid flow through the fluid flow passageway when the pressure at the inlet of the housing is greater than or equal to the cracking pressure.

12. The apparatus of claim 10, wherein the head portion has a threaded portion to engage the housing.

13. The apparatus of claim 12, wherein the head portion has an annular wall spaced from the body and attached to the body via a plurality of ribs, an outer surface of the annular wall having the threaded portion.

14. An apparatus comprising:

a housing defining a valve seat positioned in a fluid flow passageway between an inlet and an outlet; and
 a flow control member positionable in the fluid flow passageway, the flow control member including:
 a body;

a disk coupled to the body, the disk having a center portion coupled to the body and a peripheral edge extending from the center portion, the peripheral edge of the disk is to seal against the valve seat to prevent fluid flow through the fluid flow passageway when a pressure at an inlet of the housing is less than a cracking pressure of the disk, and the peripheral edge is to move away from the valve seat to allow fluid flow through the fluid flow passageway when the pressure at the inlet of the housing is greater than or equal to the cracking pressure; and

a head portion to couple the flow control member to the housing, the body being adjustable relative to the housing via the head portion to provide a preload to the disk corresponding to the cracking pressure.

15. An apparatus comprising:

a bonnet having a cavity and defining an outlet;
 a valve body to be coupled to the bonnet, the valve body defining an opening including a first valve seat, a second valve seat and an inlet; and

a poppet having a body and a head, the head to be positioned in the cavity of the bonnet and at least a portion of the body to be positioned in the opening of the valve body, the poppet having a first disk and a second disk spaced from the first disk, the first disk having a first aperture to receive the body of the poppet

and a first peripheral edge to engage the first valve seat, the second disk having a second aperture to receive the body of the poppet and a second peripheral edge to engage the second valve seat, the head of the poppet being coupled to the bonnet via threads to enable adjustment of a preload of at least the first disk or the second disk. 5

16. The apparatus of claim 15, wherein the head includes a plurality of passageways separated by a plurality of ribs.

17. The apparatus of claim 15, wherein the valve body includes a first stepped wall to define the first valve seat and a second stepped wall to define the second valve seat. 10

18. The apparatus of claim 15, wherein a first inner edge defined by the first aperture of the first disk is fixedly attached to the poppet and the first peripheral edge moves relative to the first inner edge, and a second inner edge defined by the second aperture of the second disk is fixedly attached to the poppet and the second peripheral edge moves relative to the second inner edge. 15

19. The apparatus of claim 15, wherein the body includes a third valve seat and the poppet includes a third disk, the third disk being spaced from the first disk and the second disk, the third disk having a third aperture to receive the body of the poppet and a third peripheral edge to engage the third valve seat. 20 25

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